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Dojan et al.

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(54) **ARTICLE OF FOOTWEAR HAVING A FLUID-FILLED BLADDER WITH A REINFORCING STRUCTURE**

(75) Inventors: **Frederick J. Dojan**, Vancouver, WA (US); **Troy C. Lindner**, Portland, OR (US); **Scott C. Holt**, Portland, OR (US)

(73) Assignee: **Nike, Inc.**, Beaverton, OR (US)

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(21) Appl. No.: **12/117,171**

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Related U.S. Application Data

(60) Division of application No. 11/251,622, filed on Oct. 14, 2005, which is a continuation-in-part of application No. 10/767,211, filed on Jan. 28, 2004, now Pat. No. 7,086,179.

(60) Provisional application No. 60/531,674, filed on Dec. 23, 2003.

(51) **Int. Cl.**
A43B 13/20 (2006.01)

(52) **U.S. Cl.** **12/142 P**; 12/146 B; 36/29

(58) **Field of Classification Search** 12/142 P, 12/146 B; 36/29, 28, 153, 154, 35 B; 264/510, 264/241, 511

See application file for complete search history.

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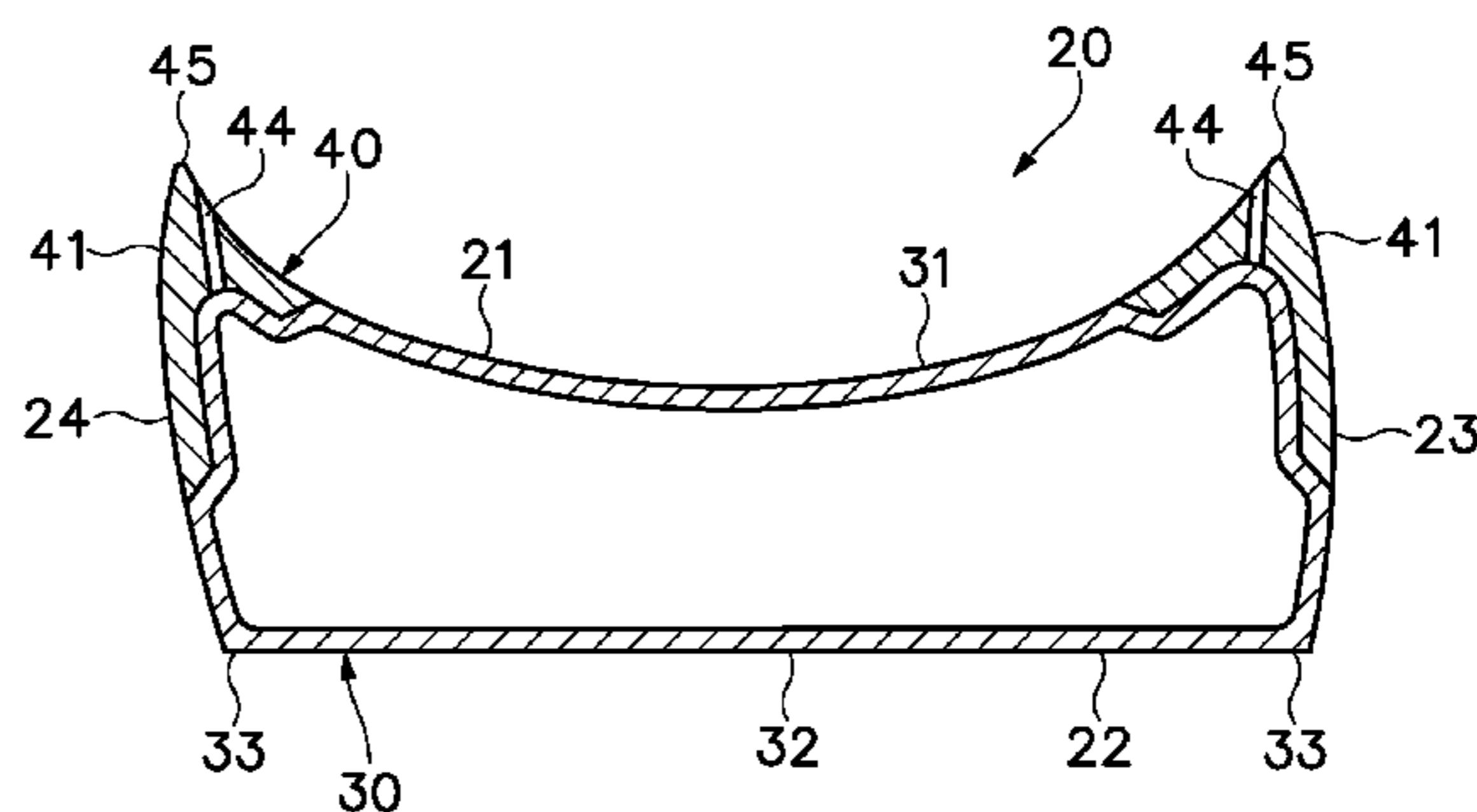
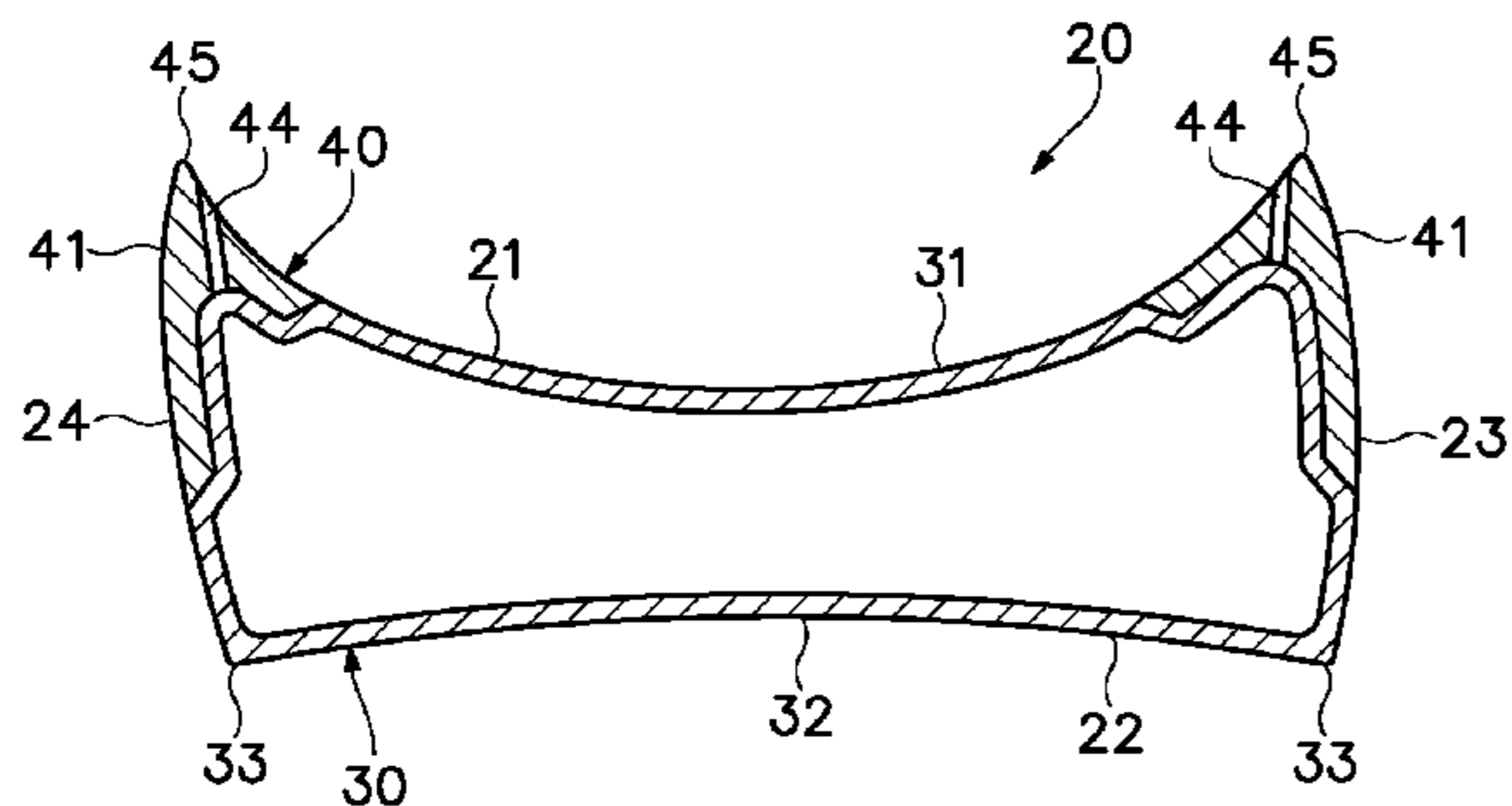
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Primary Examiner—Ted Kavanaugh
(74) *Attorney, Agent, or Firm*—Plumsea Law Group, LLC

(57) **ABSTRACT**

A sole component and a method of manufacturing the sole component are disclosed. In general, the sole component includes a fluid-filled bladder and a reinforcing structure extending around the bladder. The reinforcing structure is bonded to the exterior of the bladder, and may be recessed into the bladder. In some embodiments, the reinforcing structure extends along the side surfaces of the bladder and between upper and lower surfaces of bladder. In manufacturing the sole component, the reinforcing structure may be located within a mold, and the polymer material forming the bladder may be bonded to the reinforcing structure during the molding process.

12 Claims, 48 Drawing Sheets



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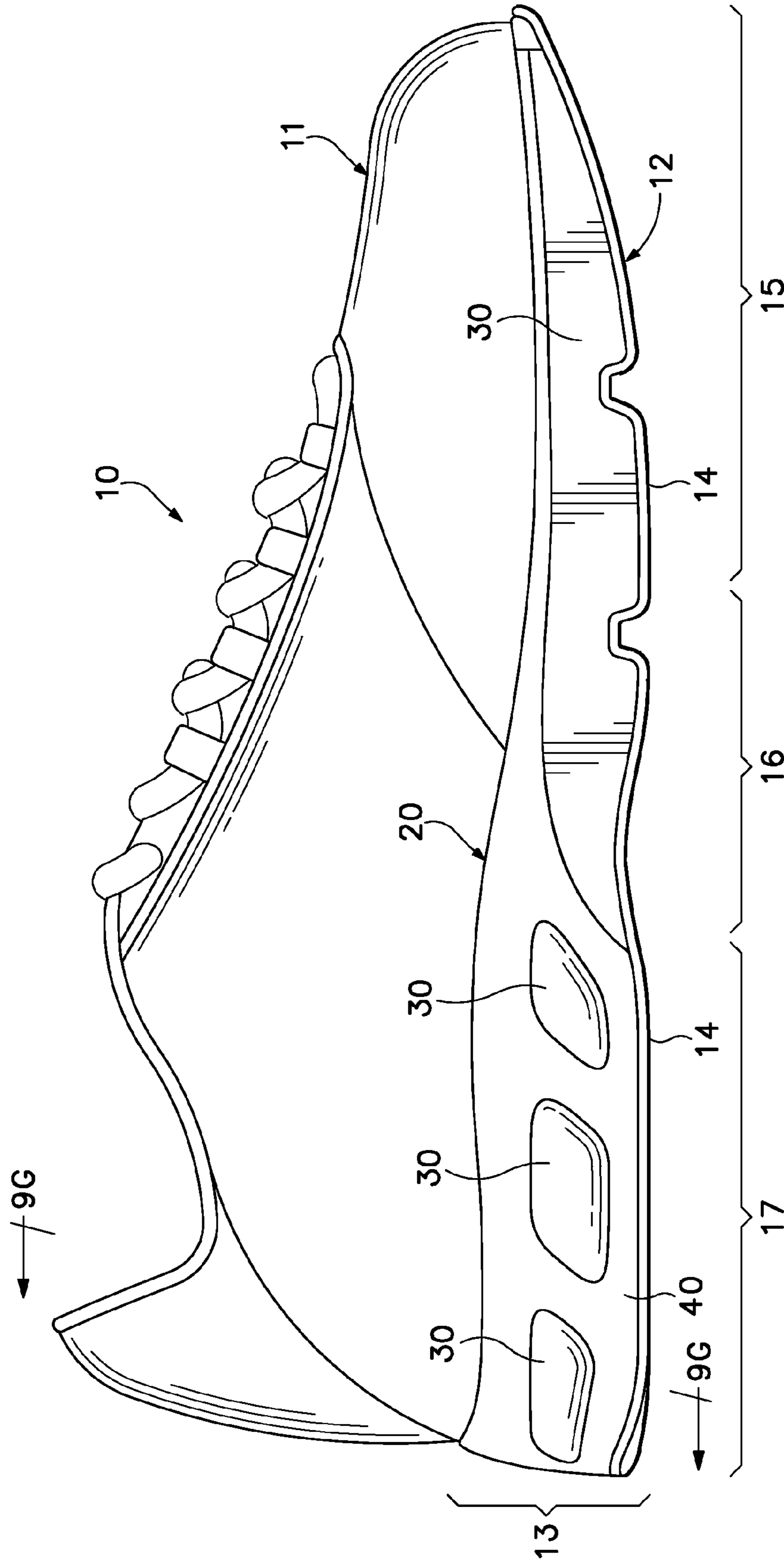


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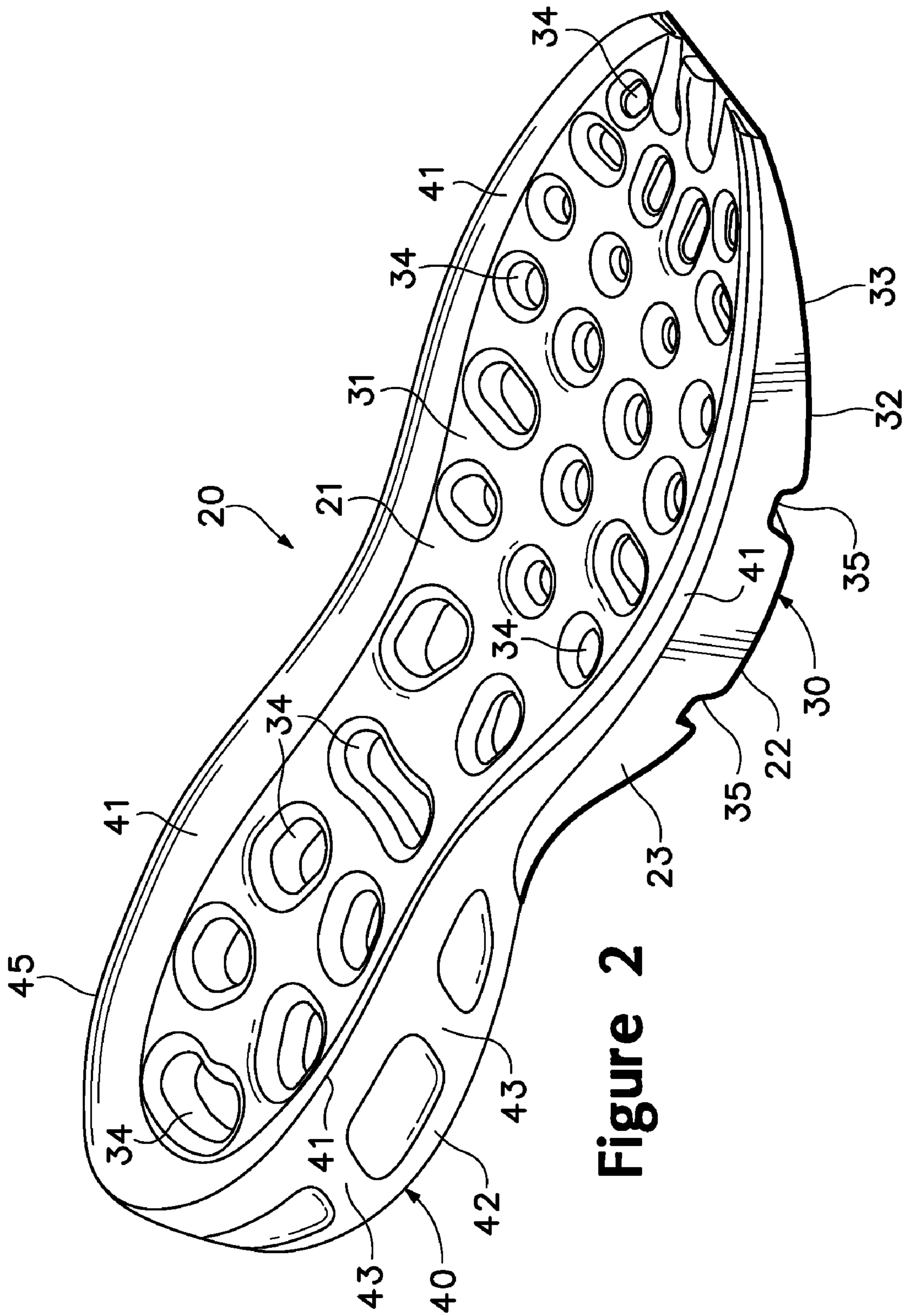


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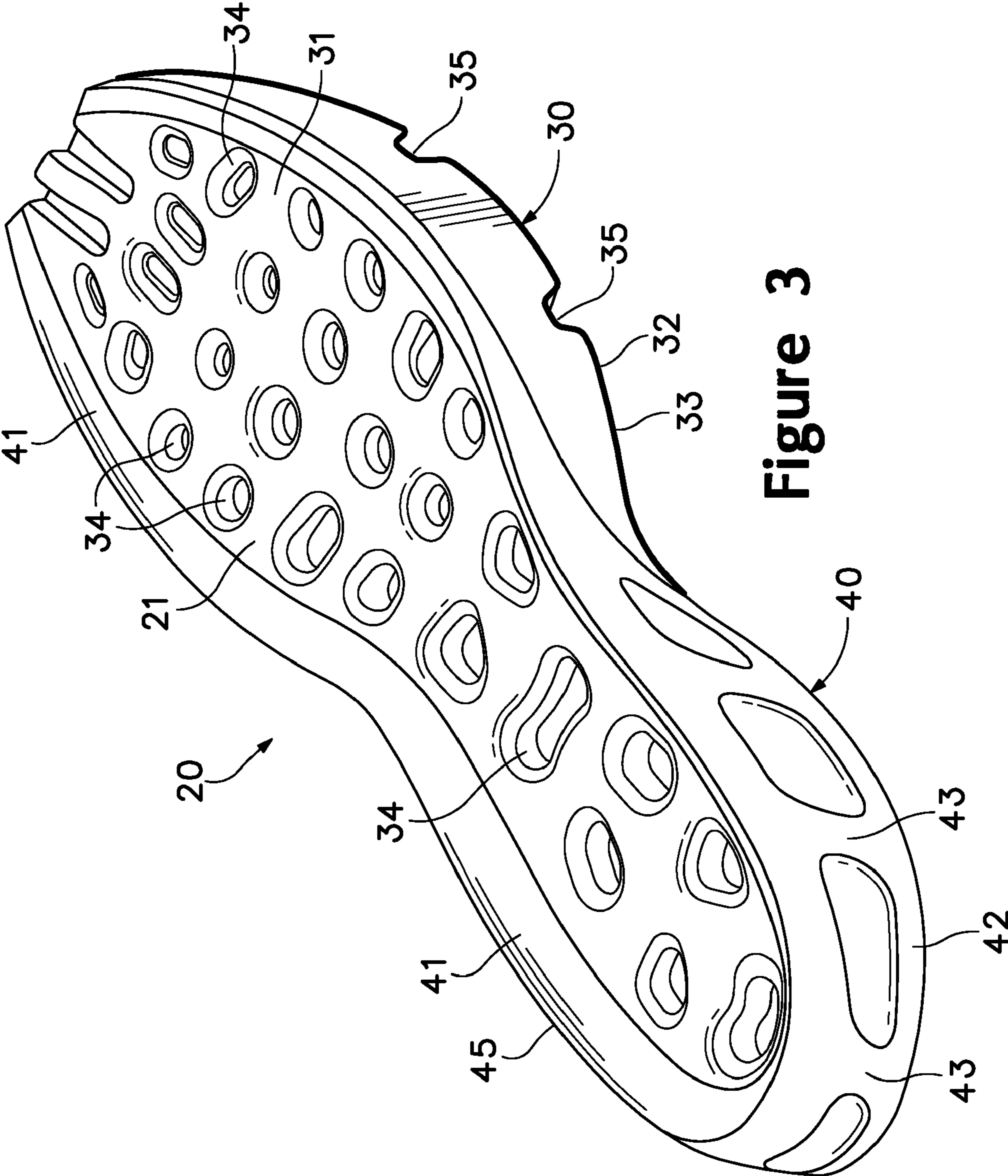


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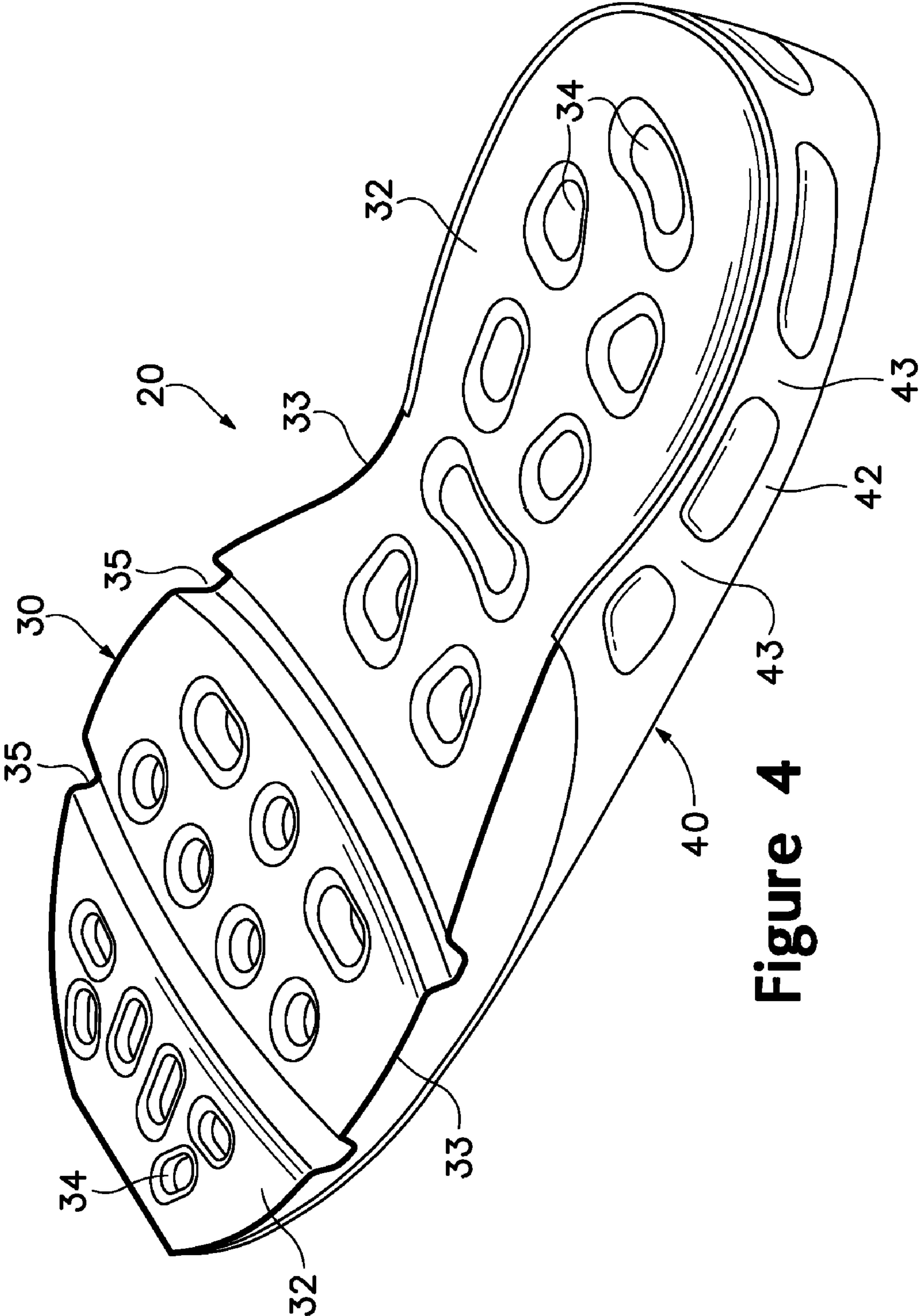


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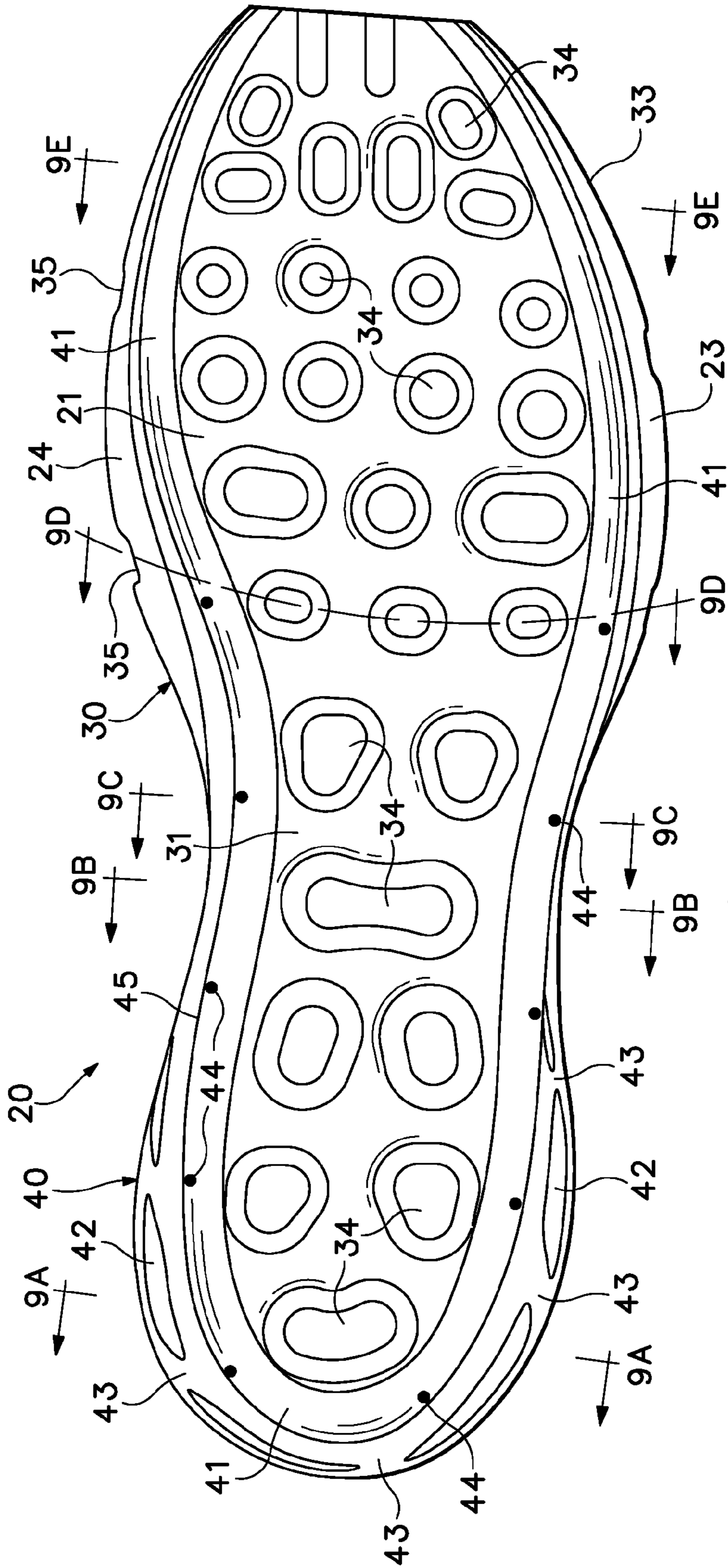


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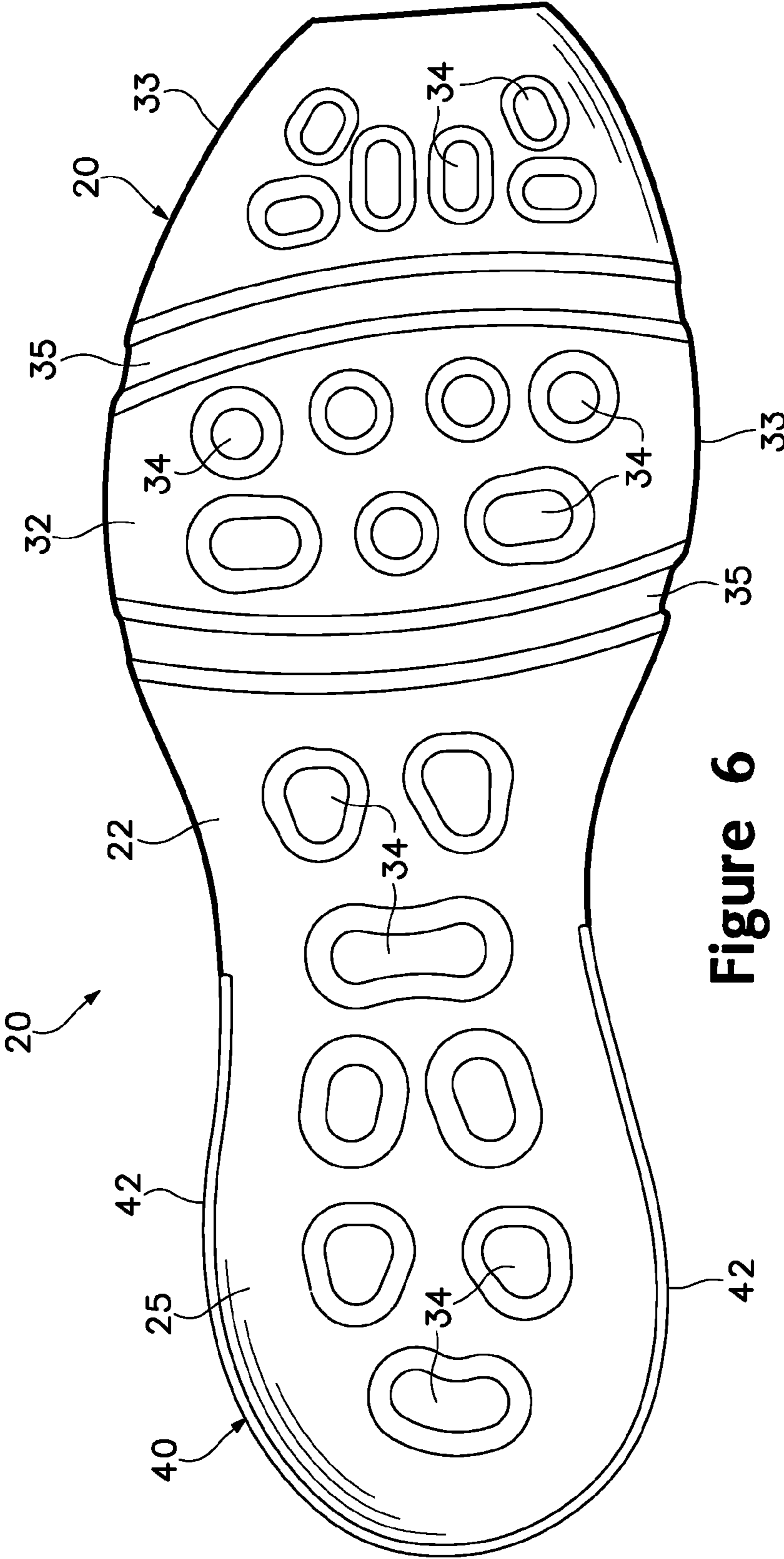


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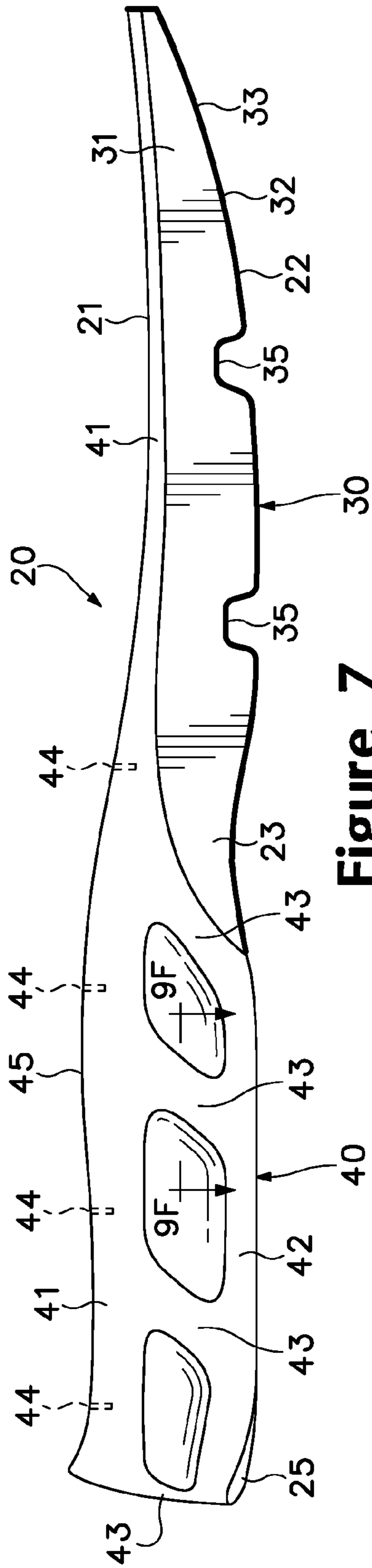


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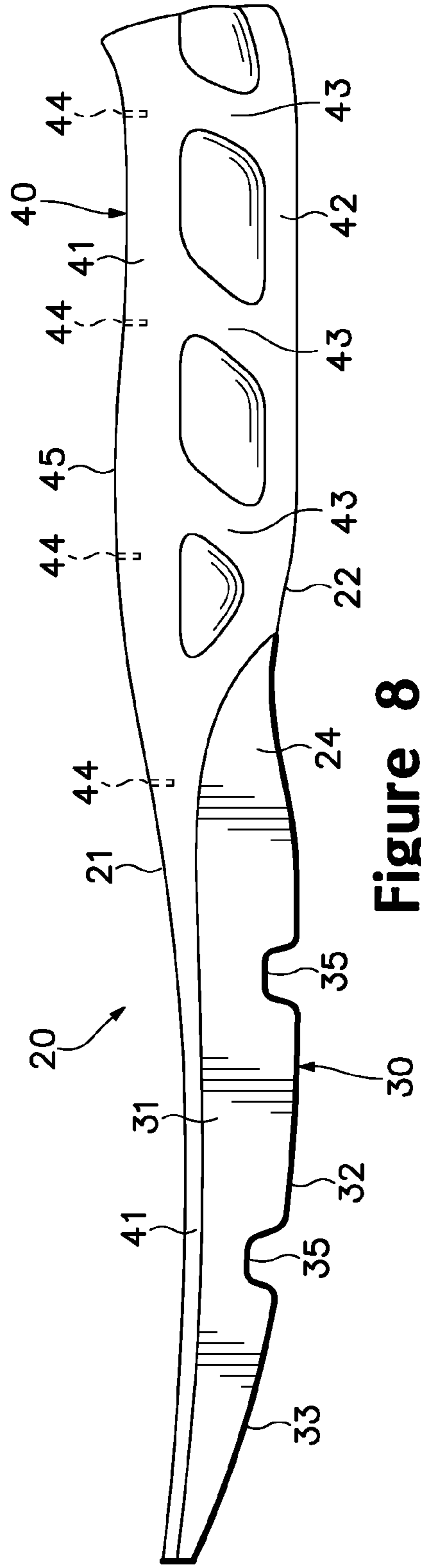


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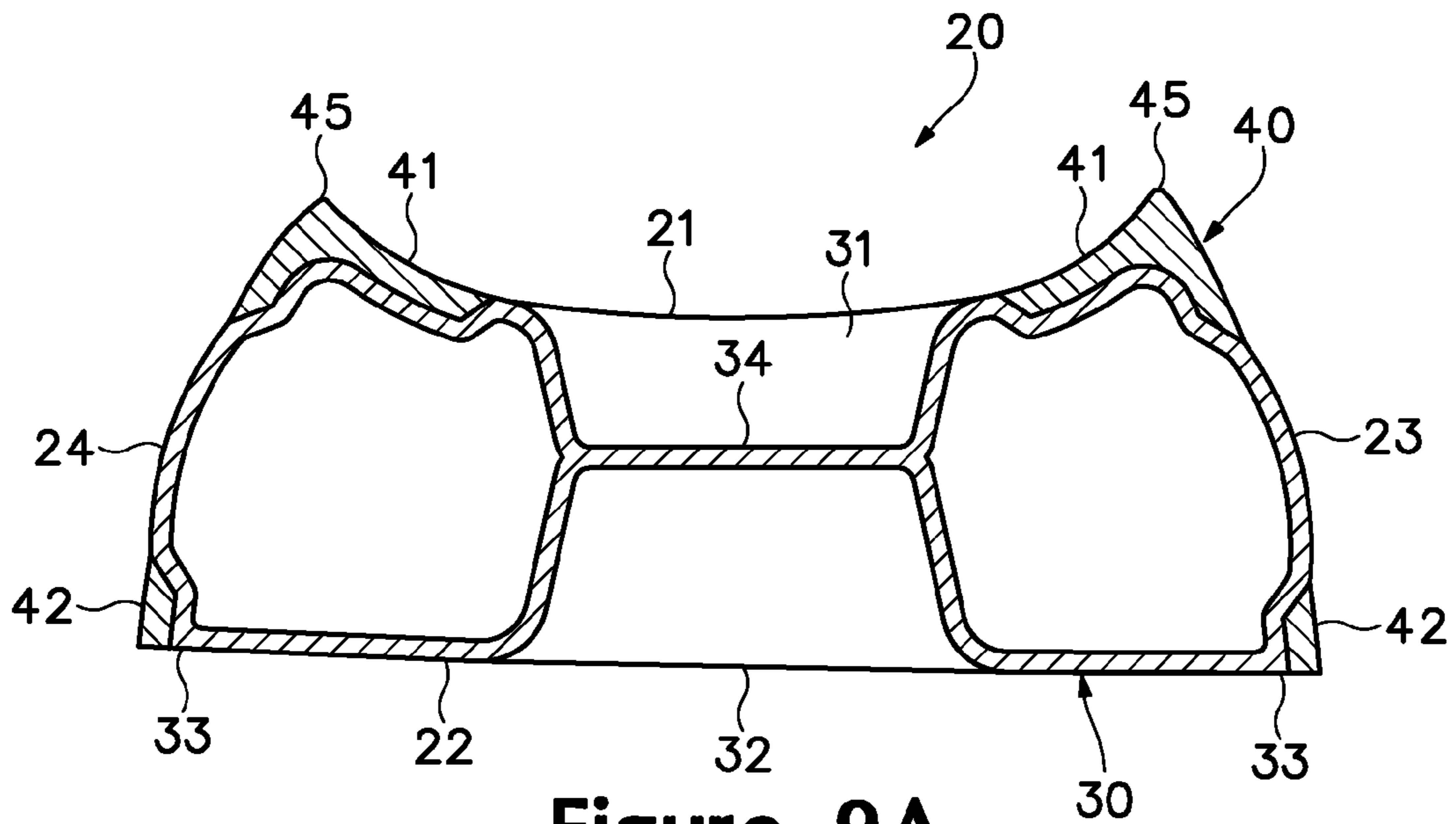


Figure 9A

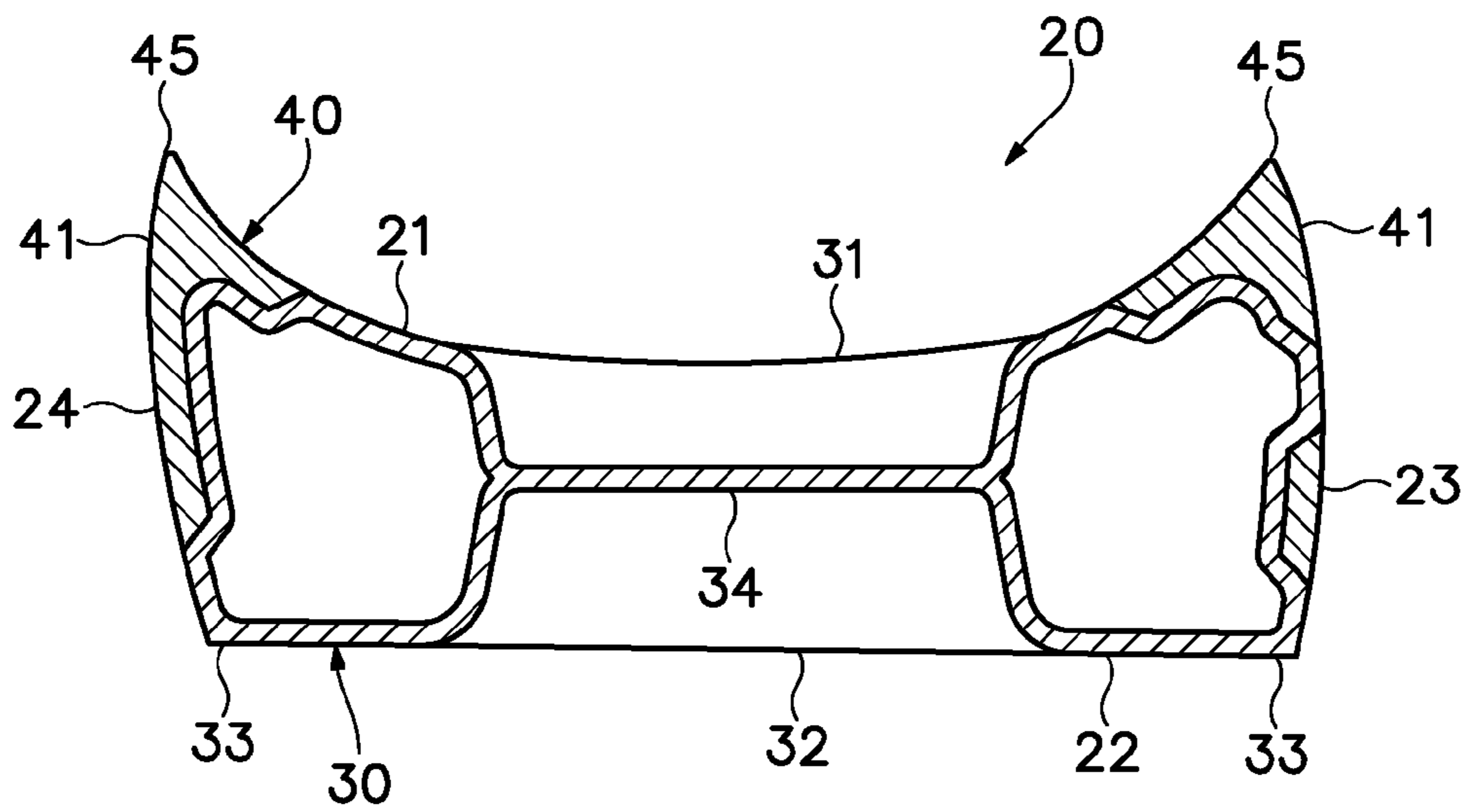


Figure 9B

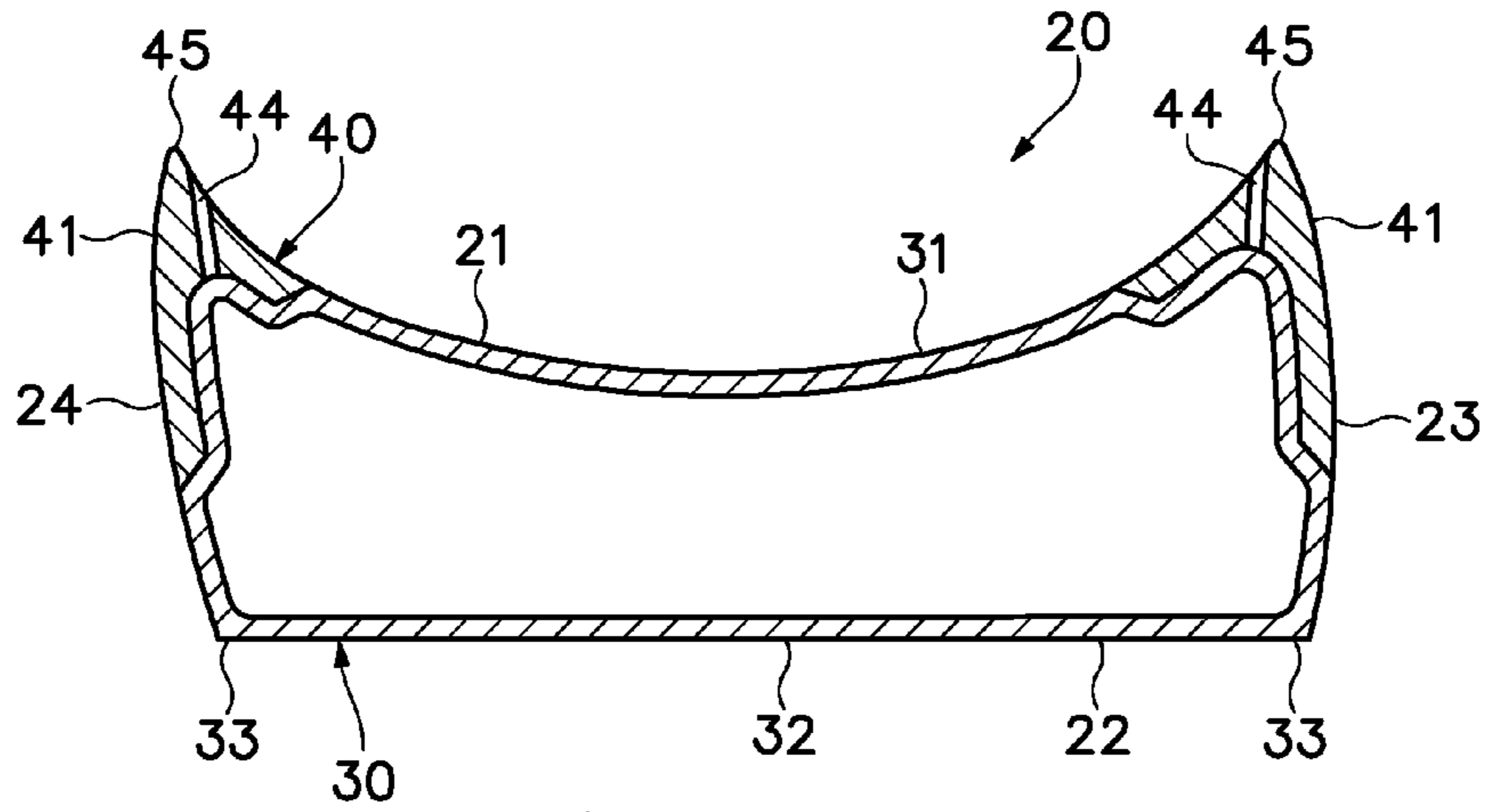


Figure 9C

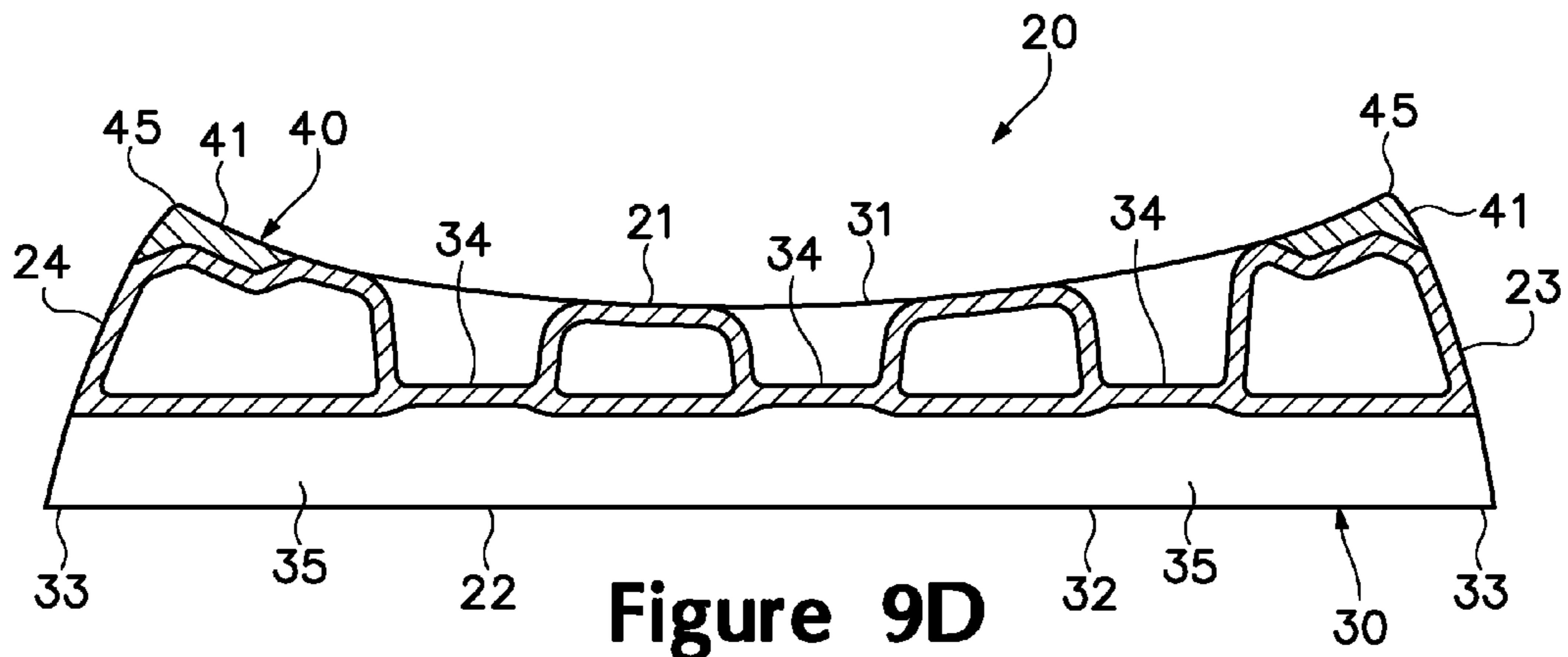


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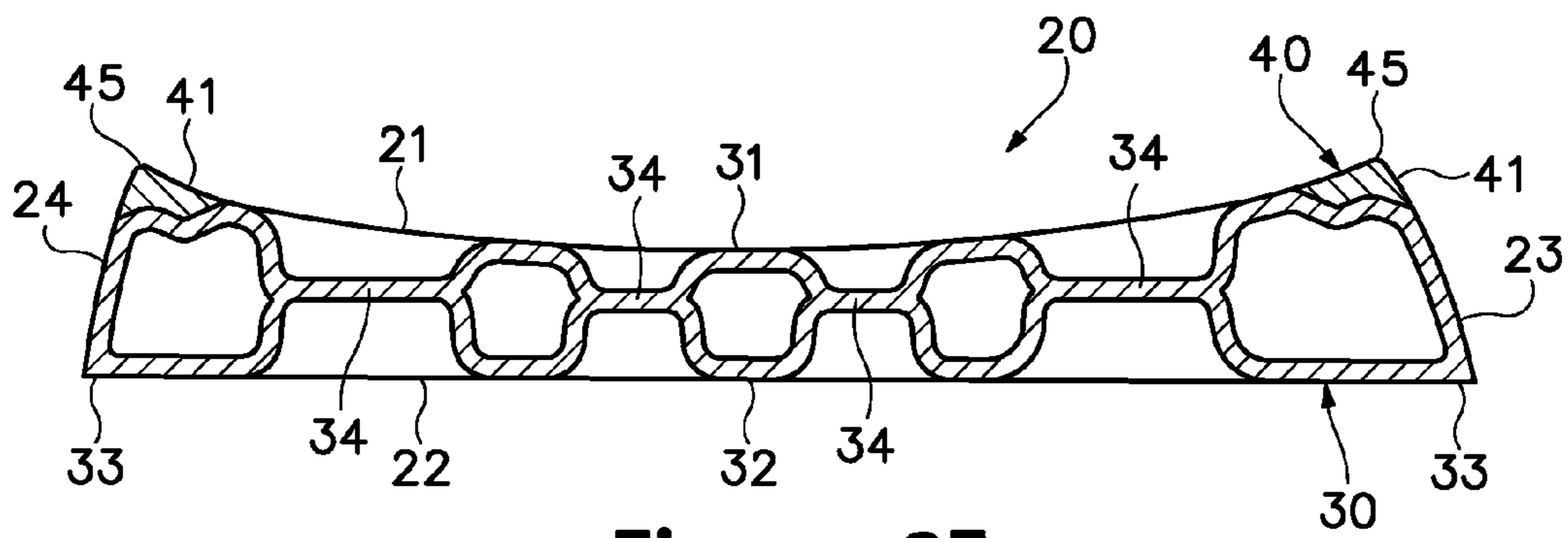


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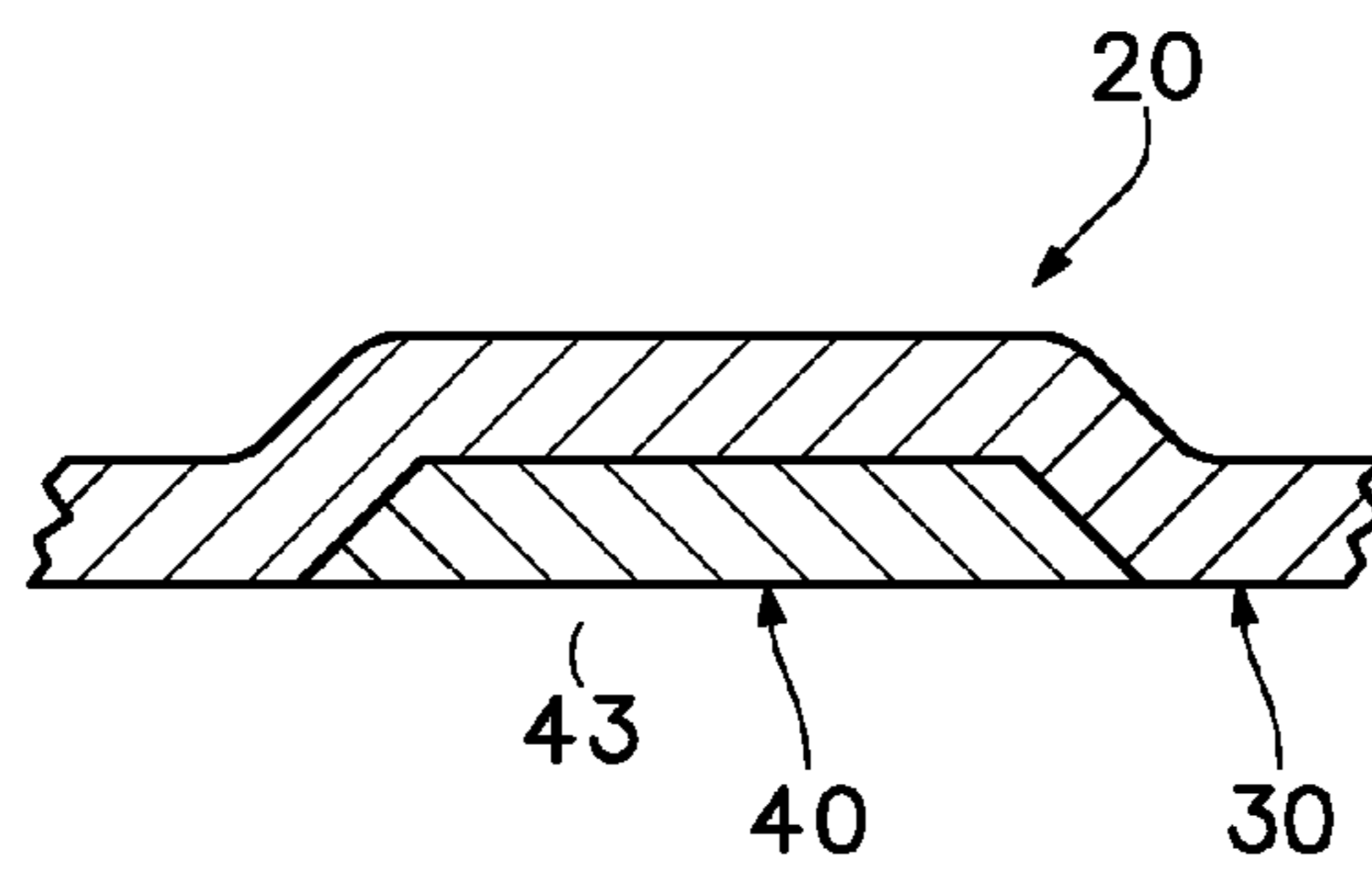


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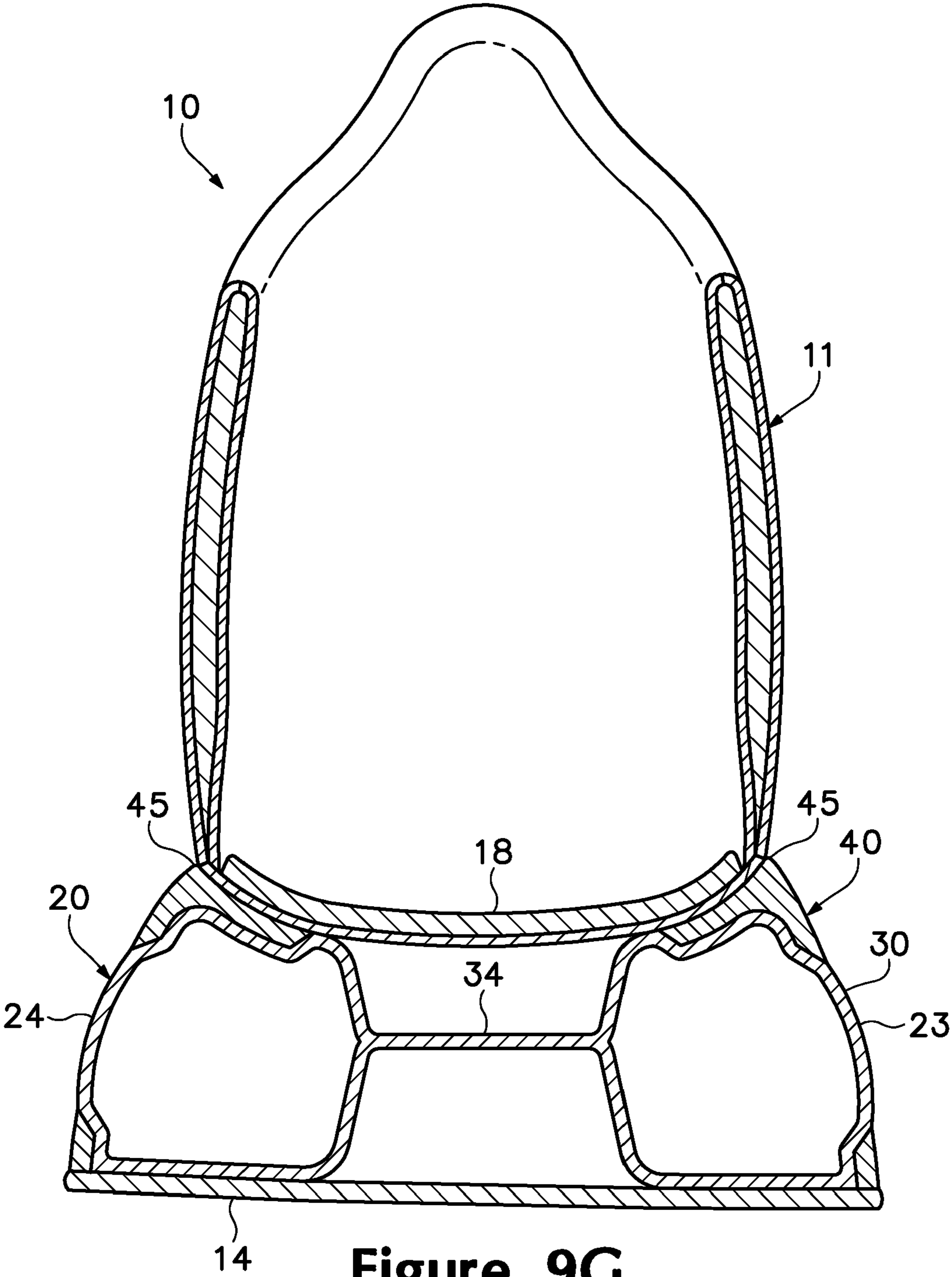


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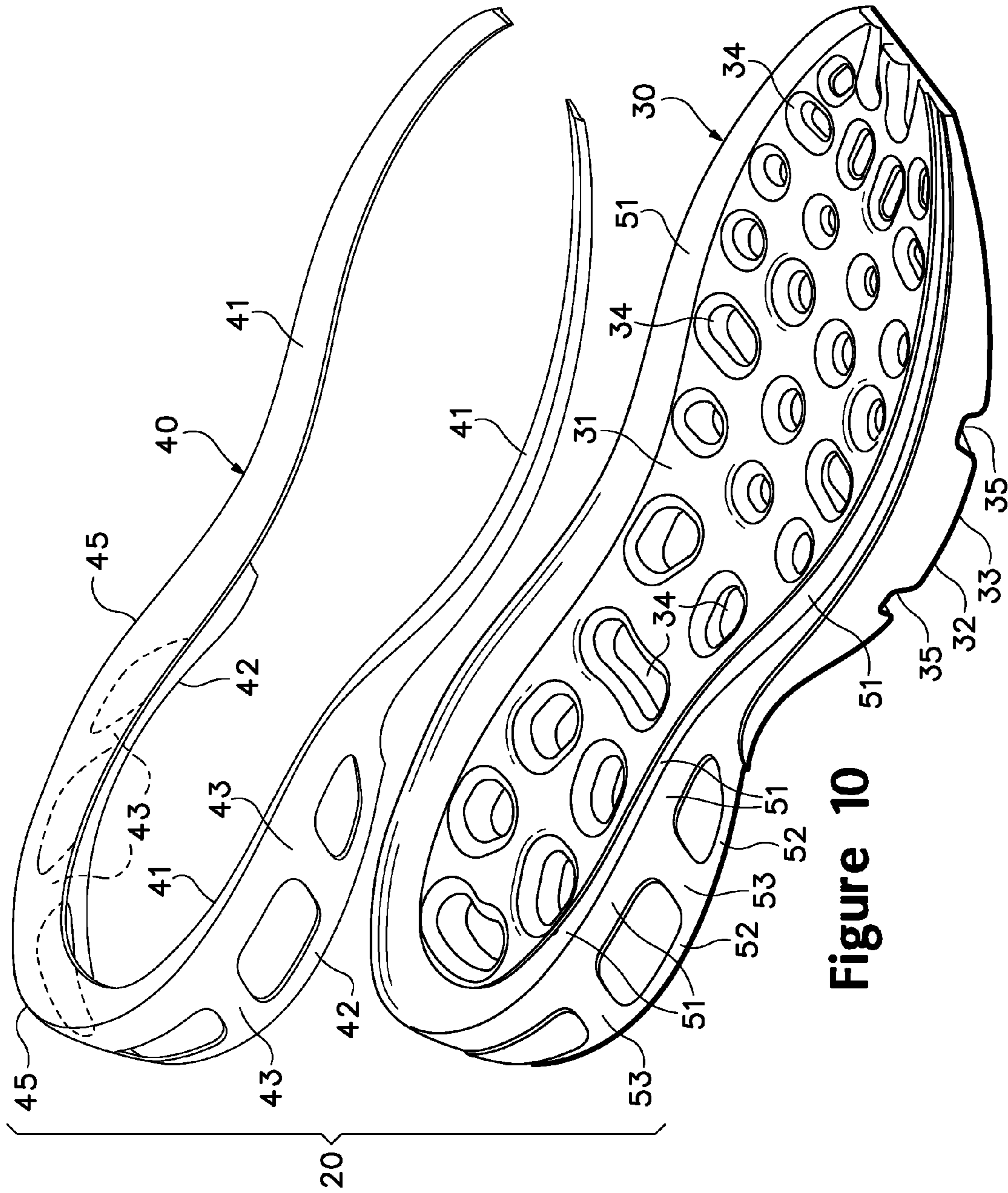


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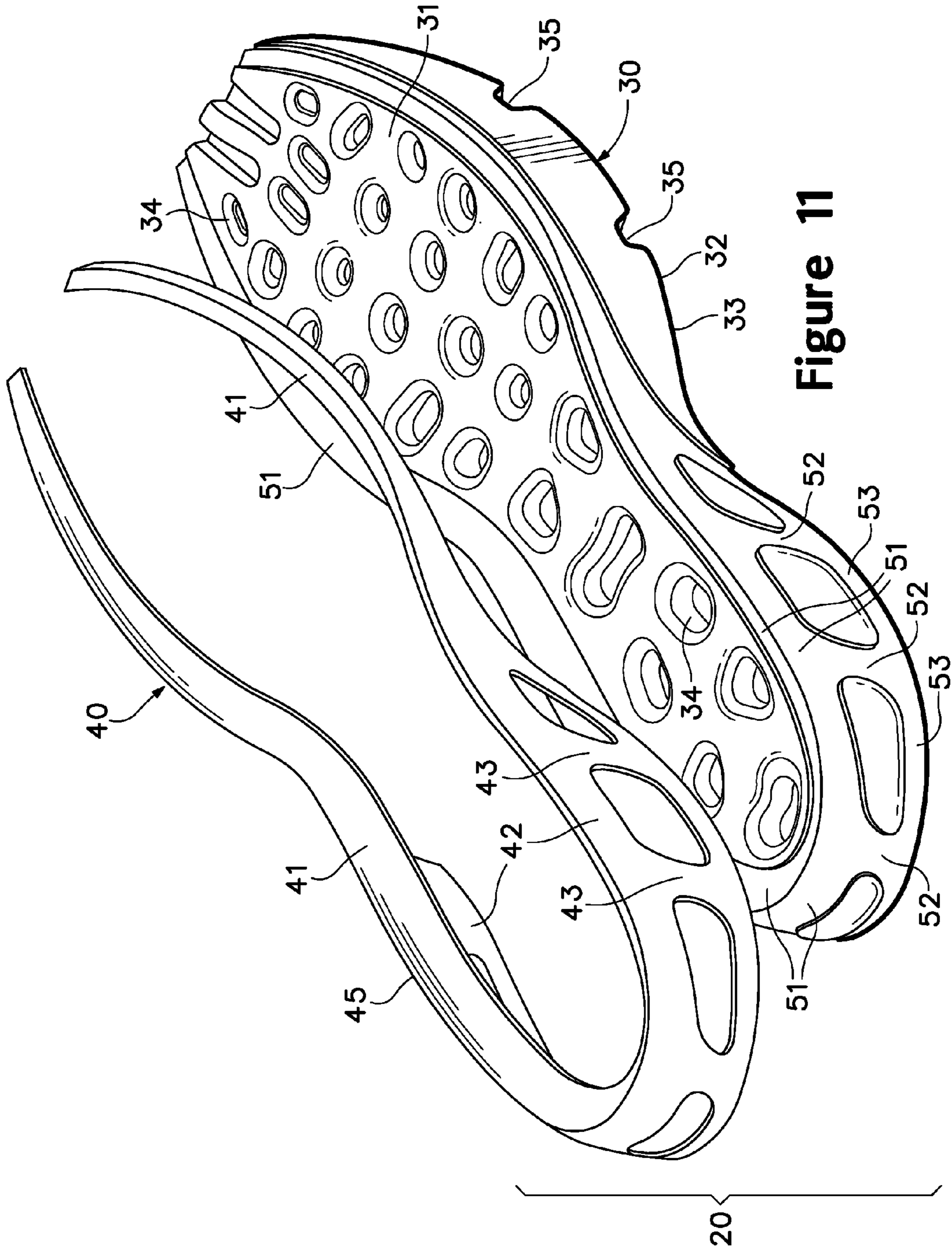


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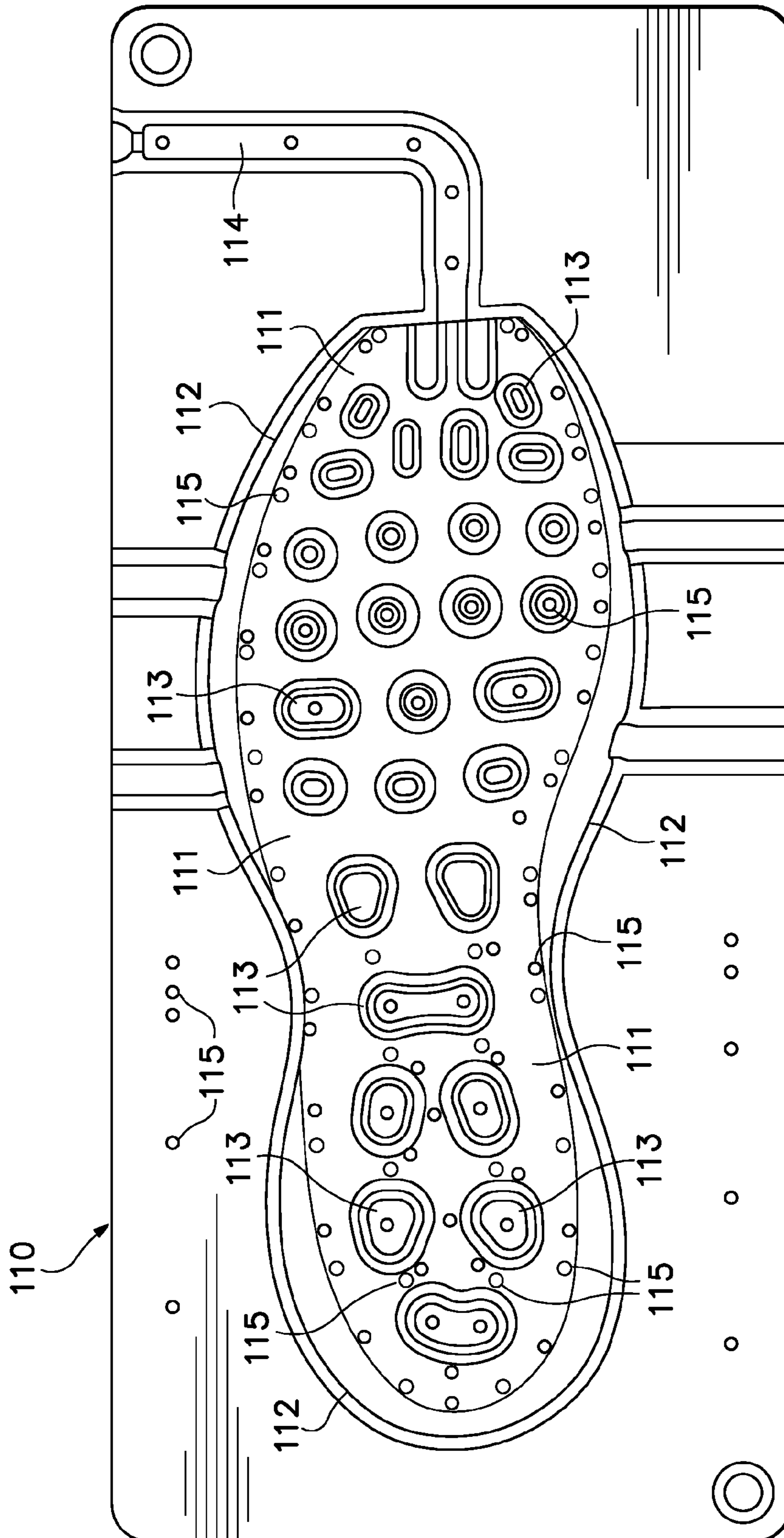


Figure 12A

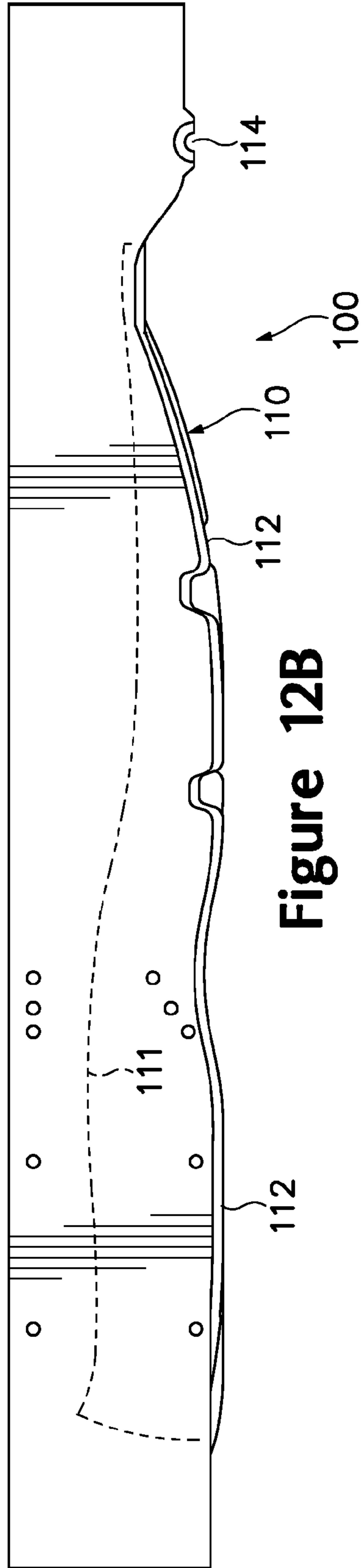


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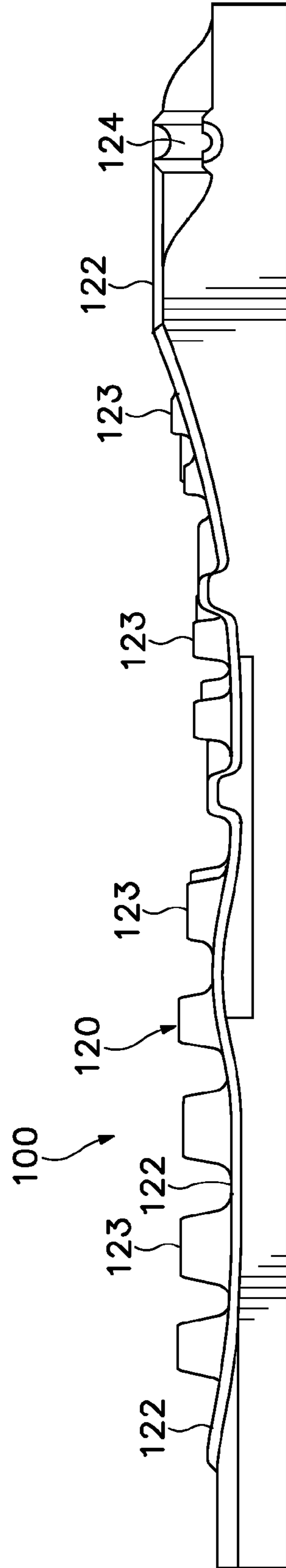


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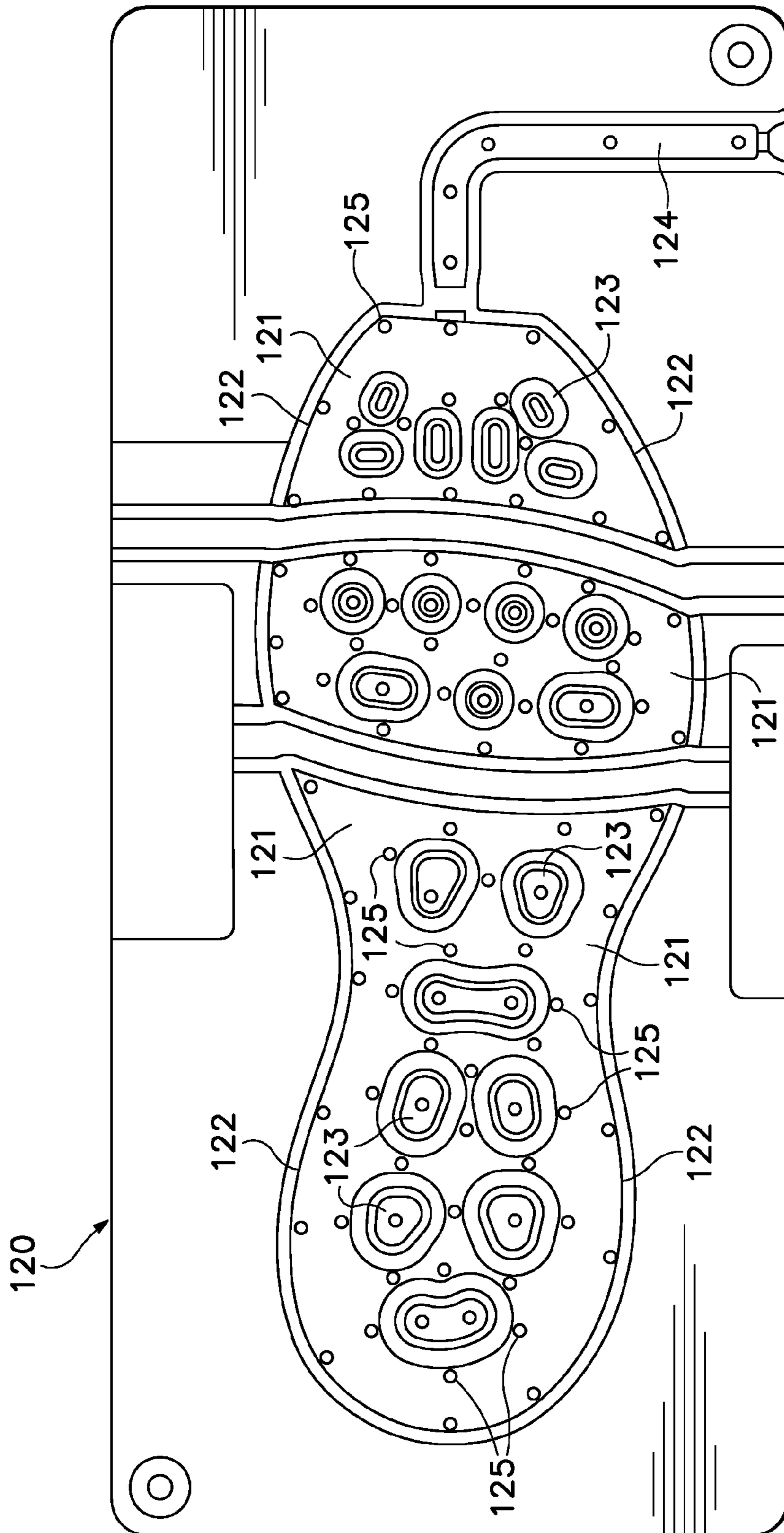


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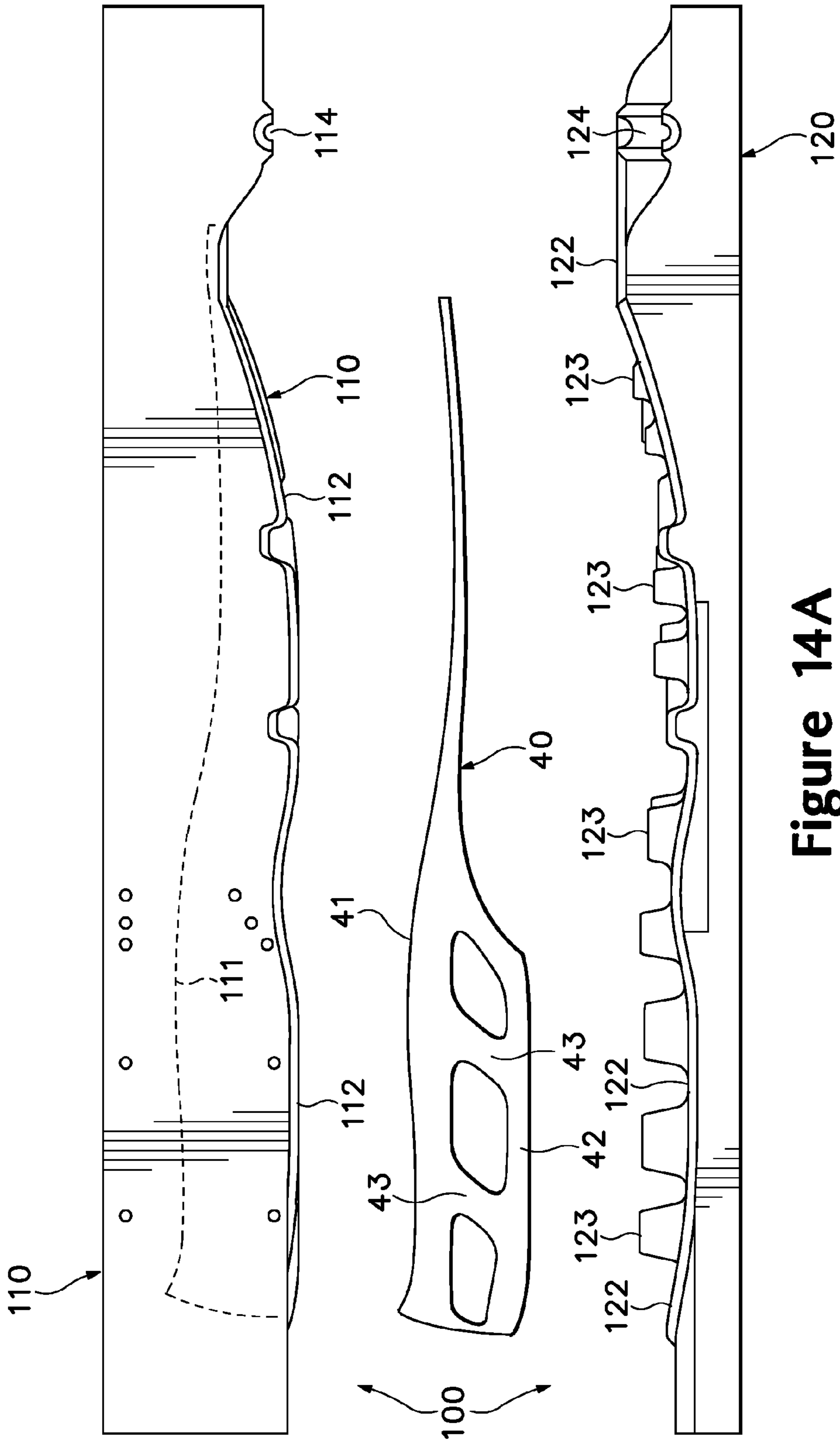


Figure 14A

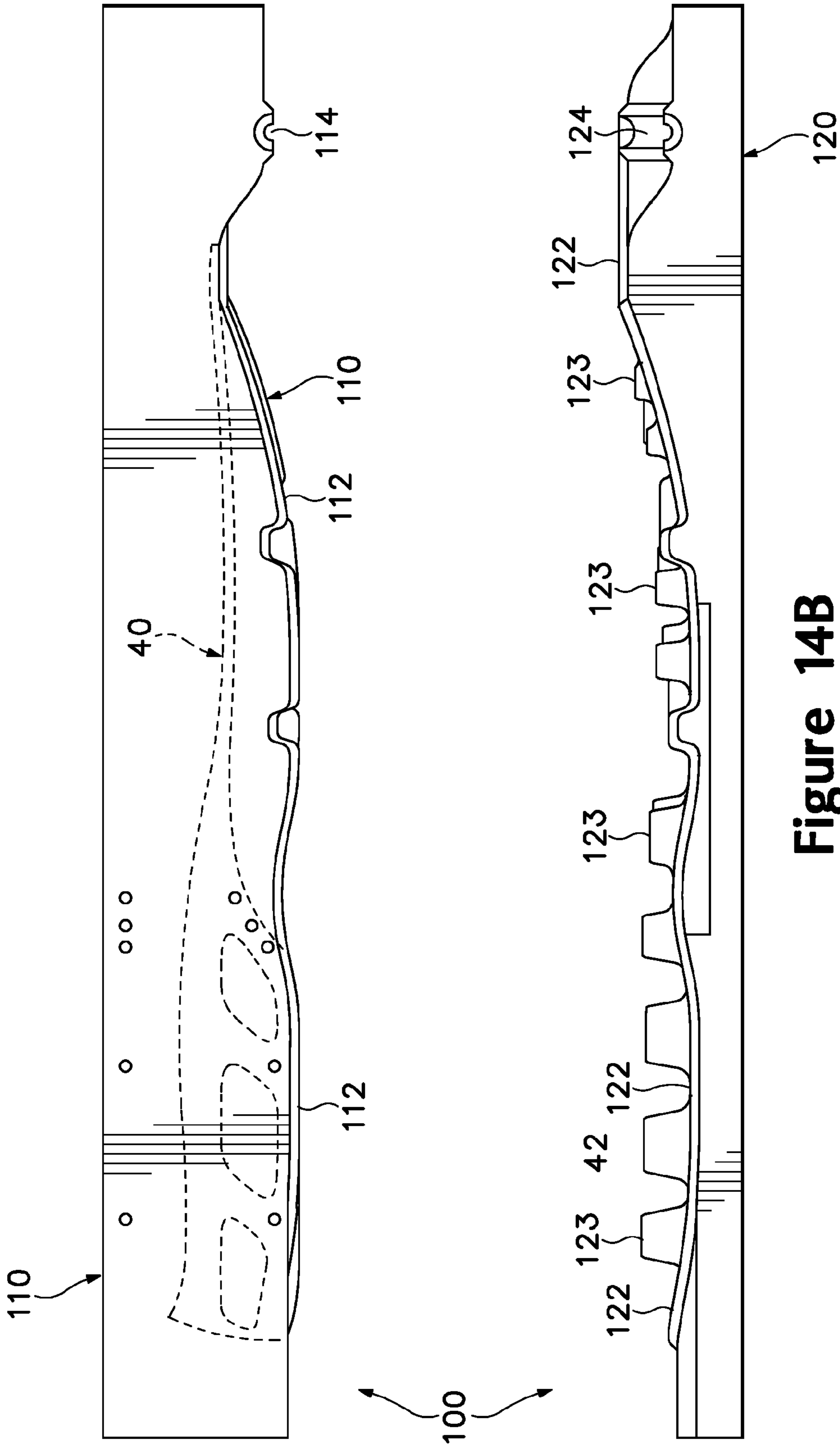


Figure 14B

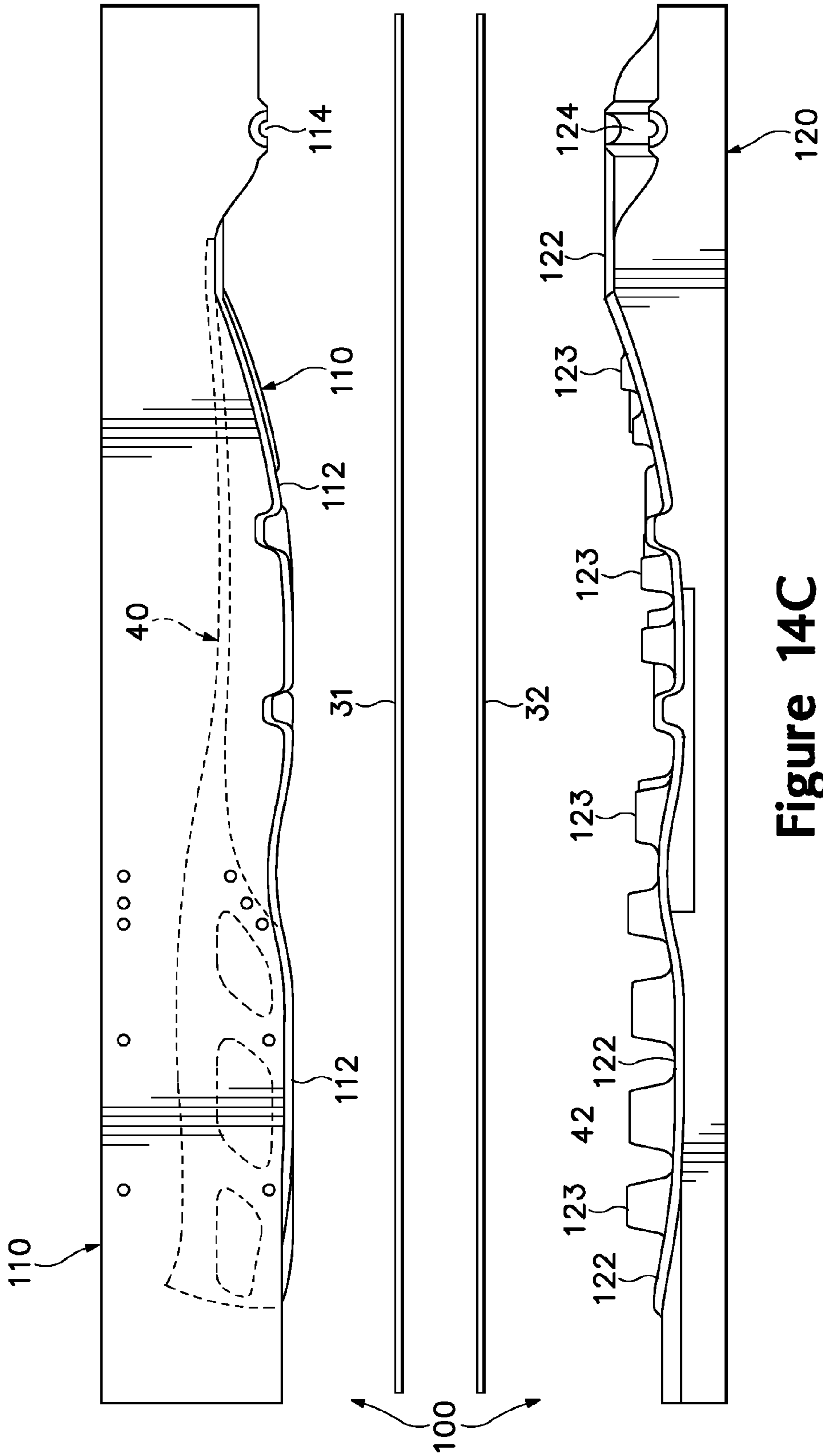


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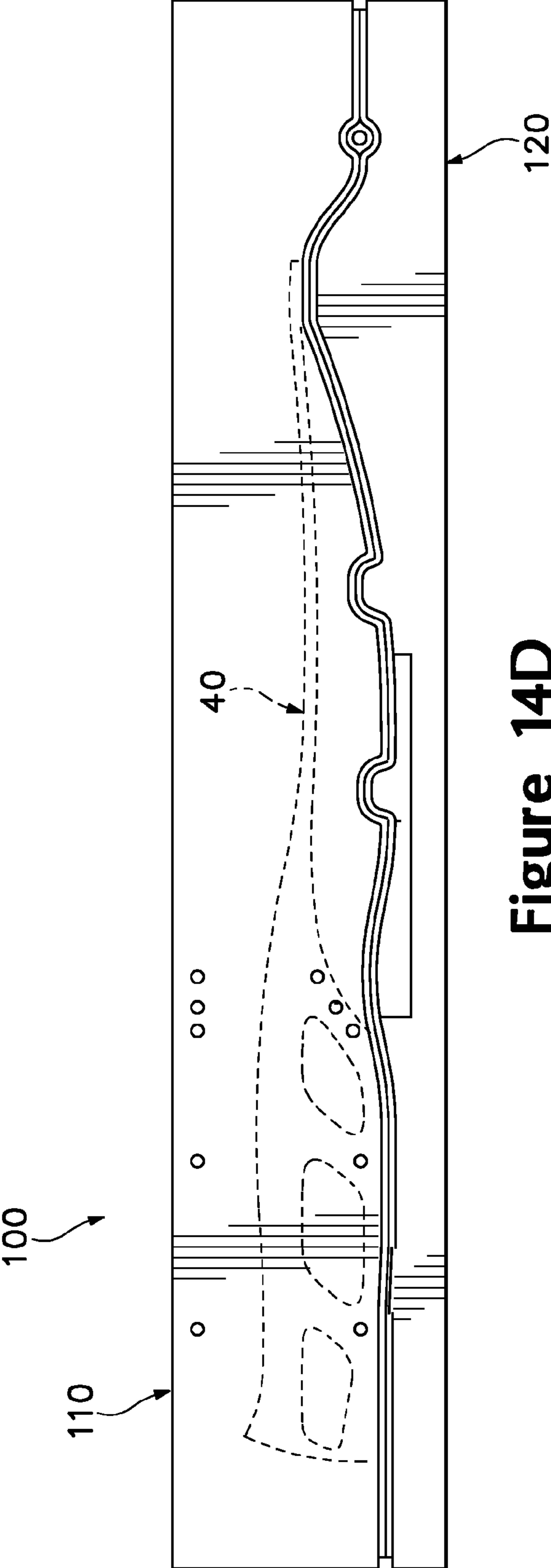


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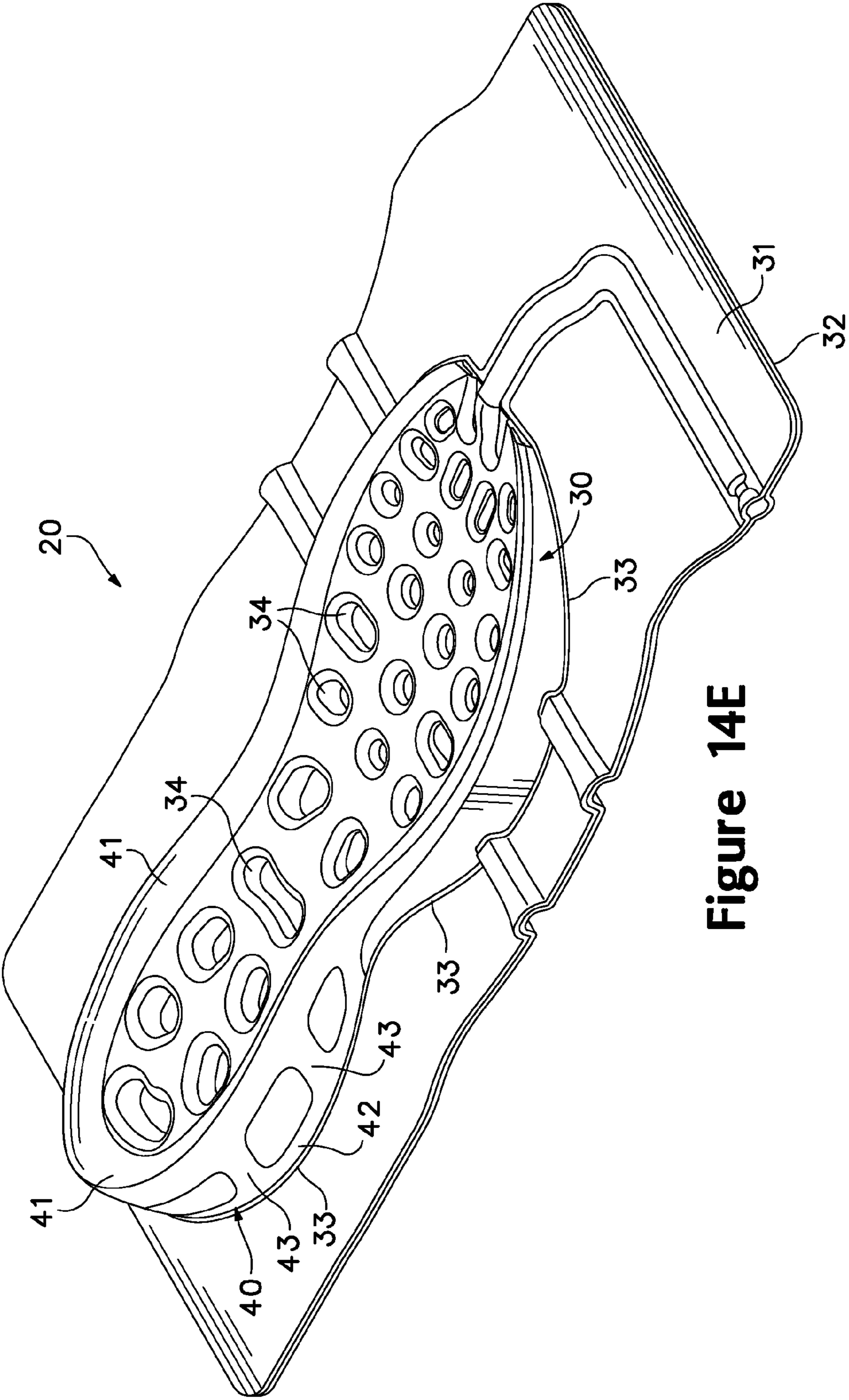


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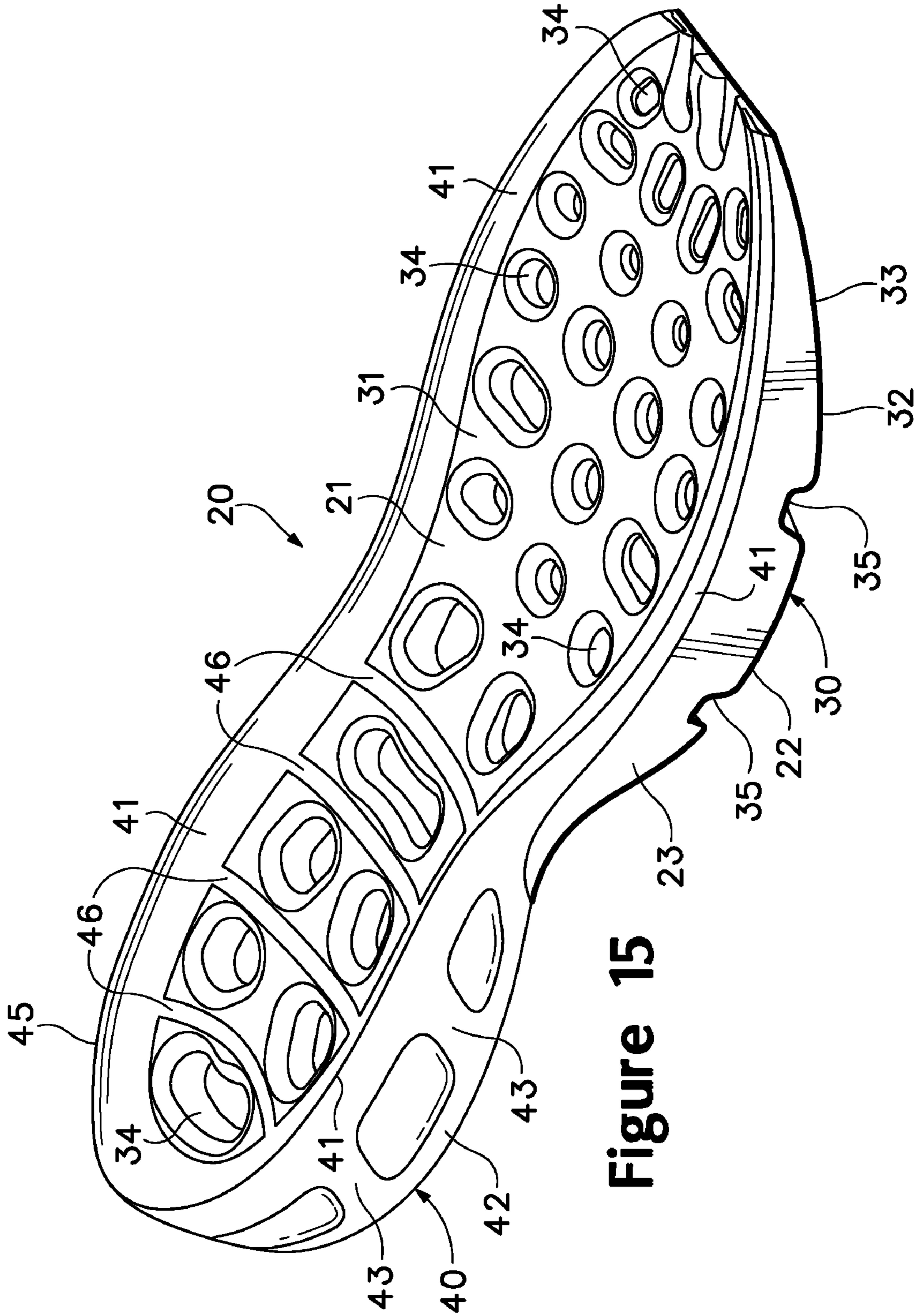


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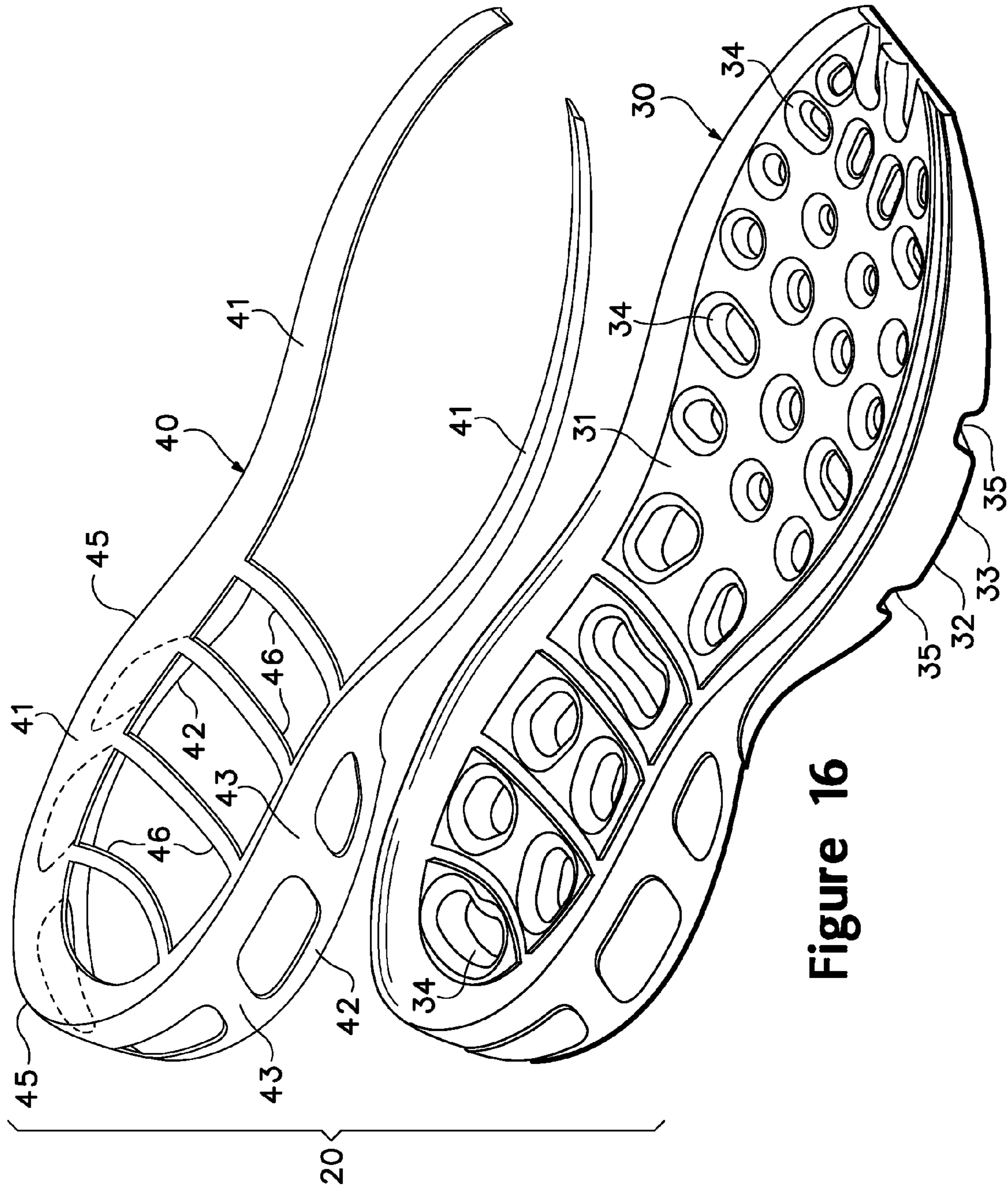


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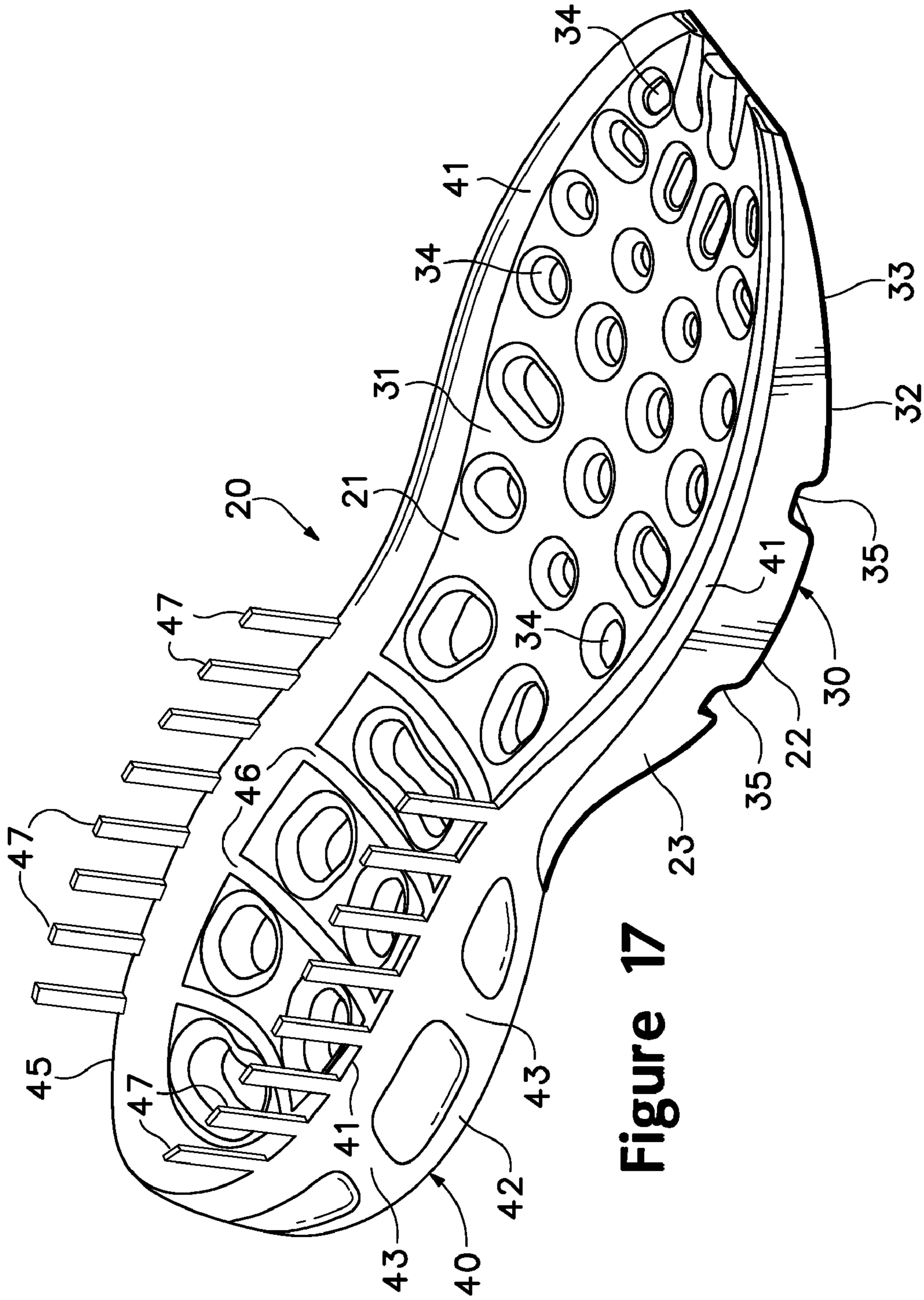


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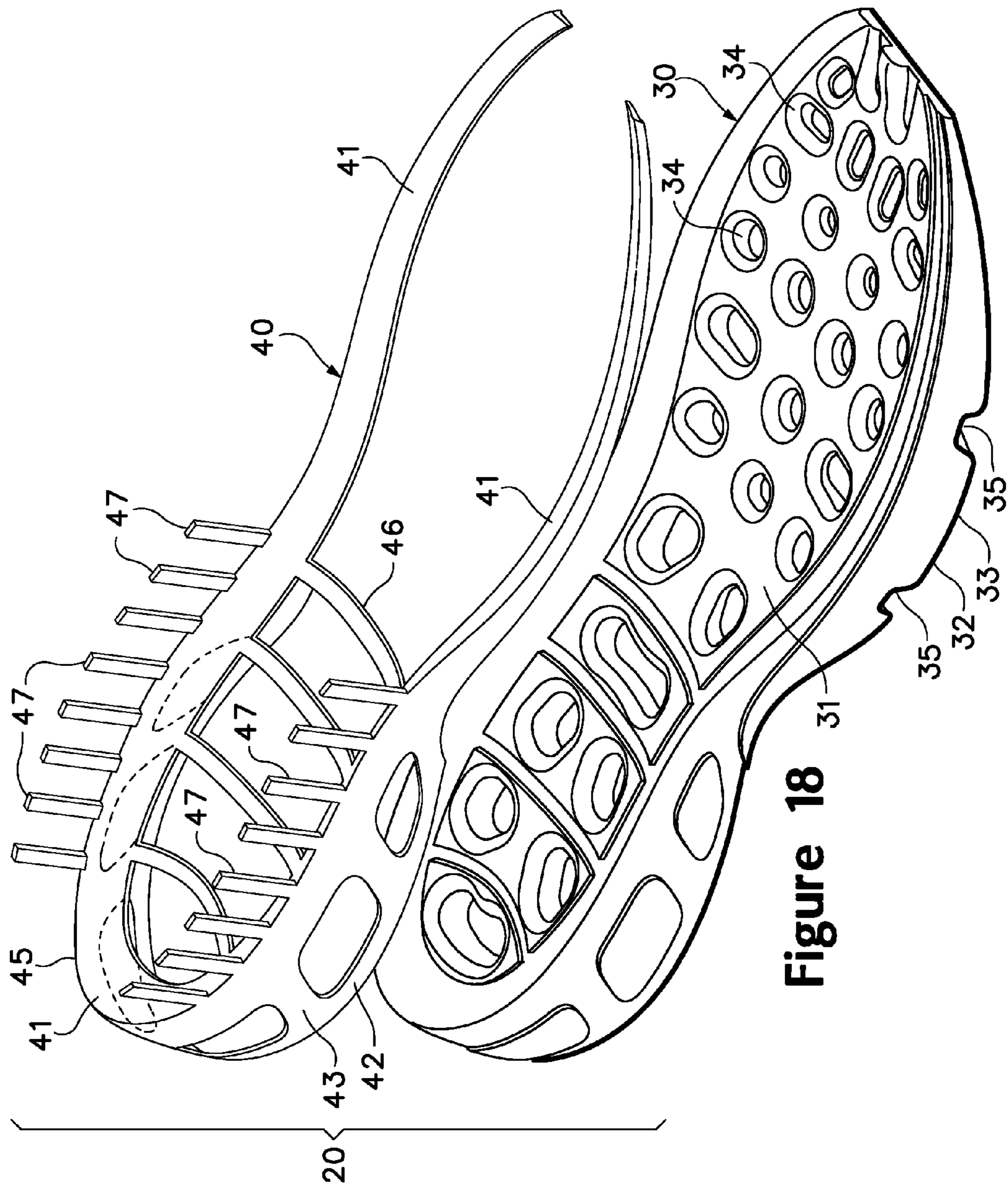


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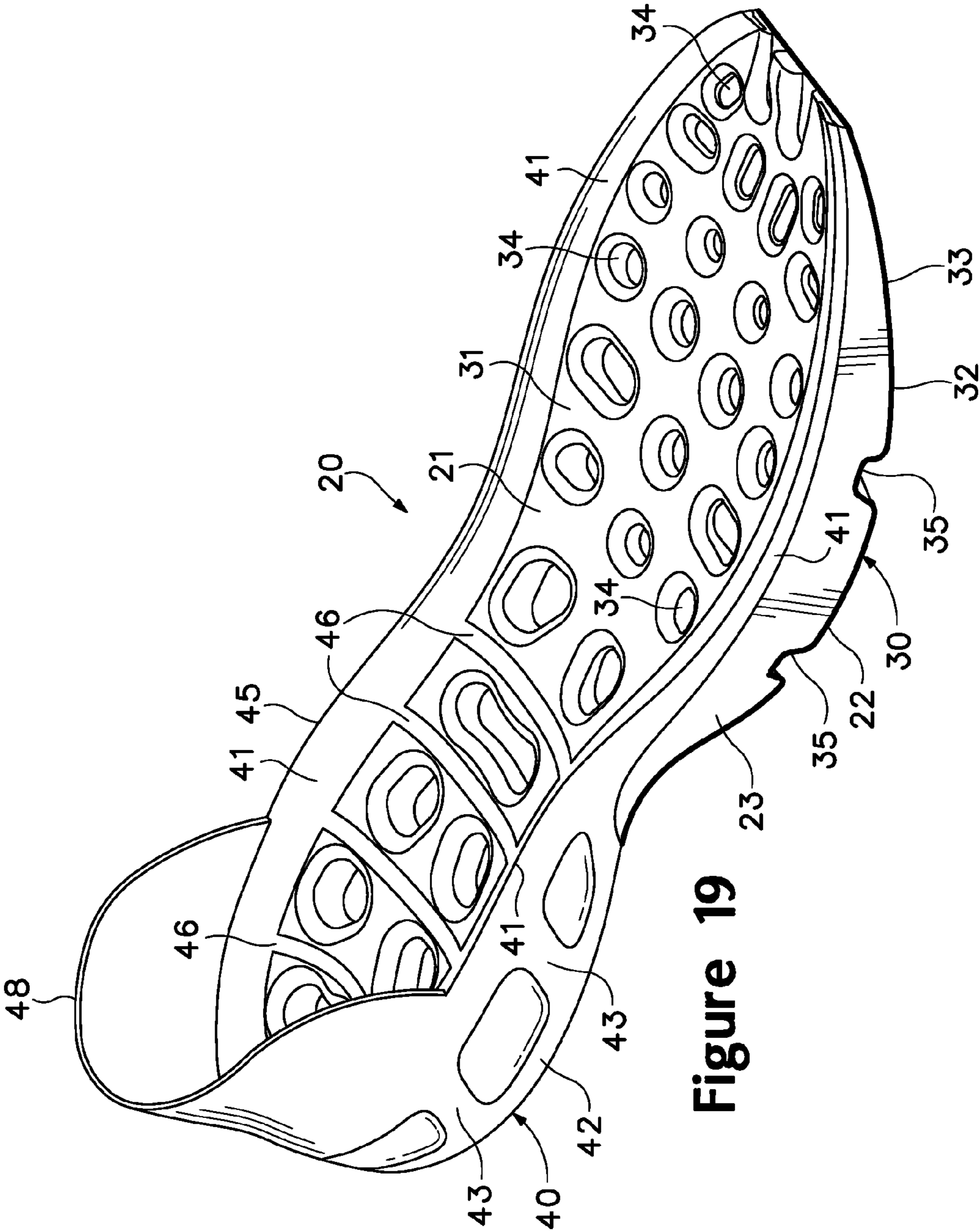


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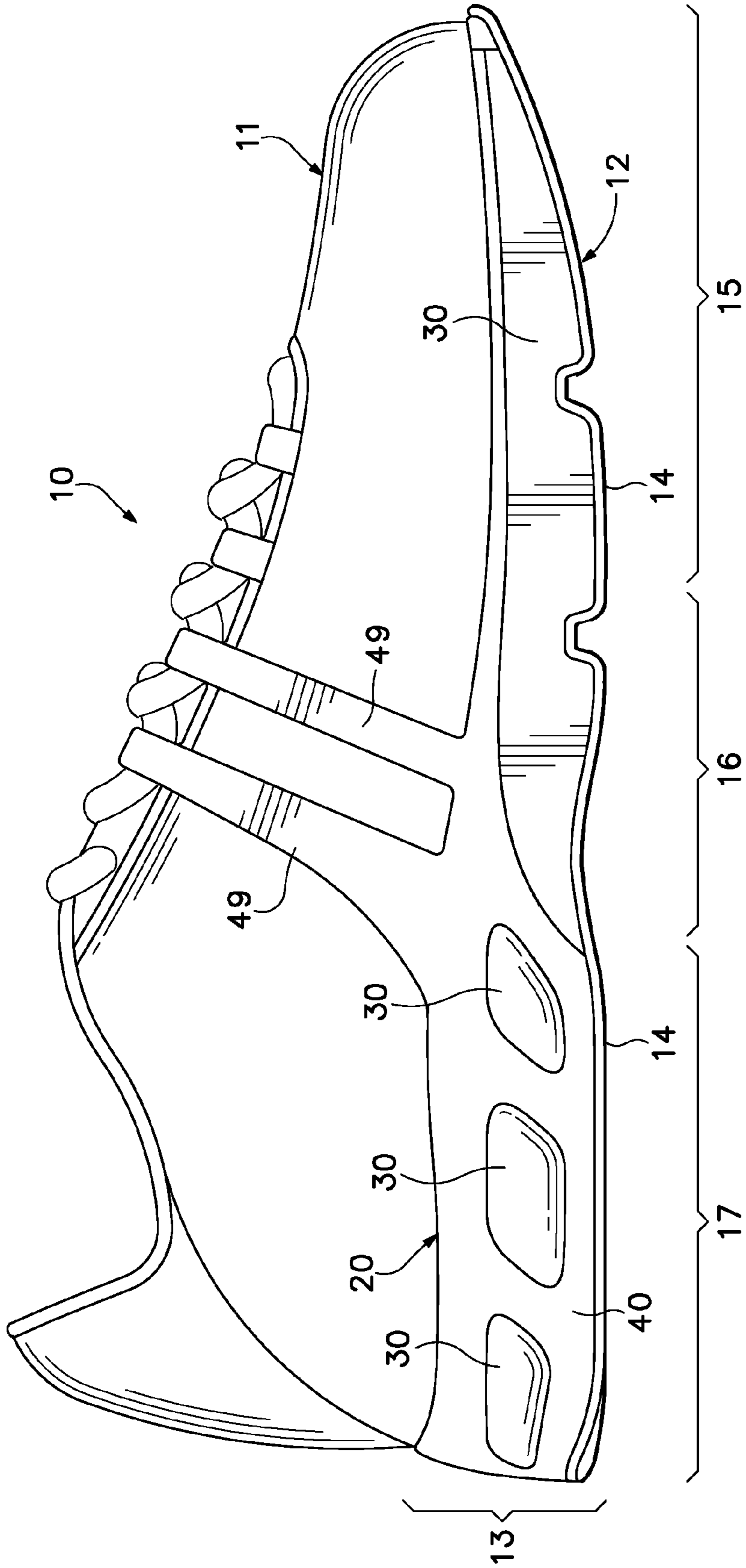


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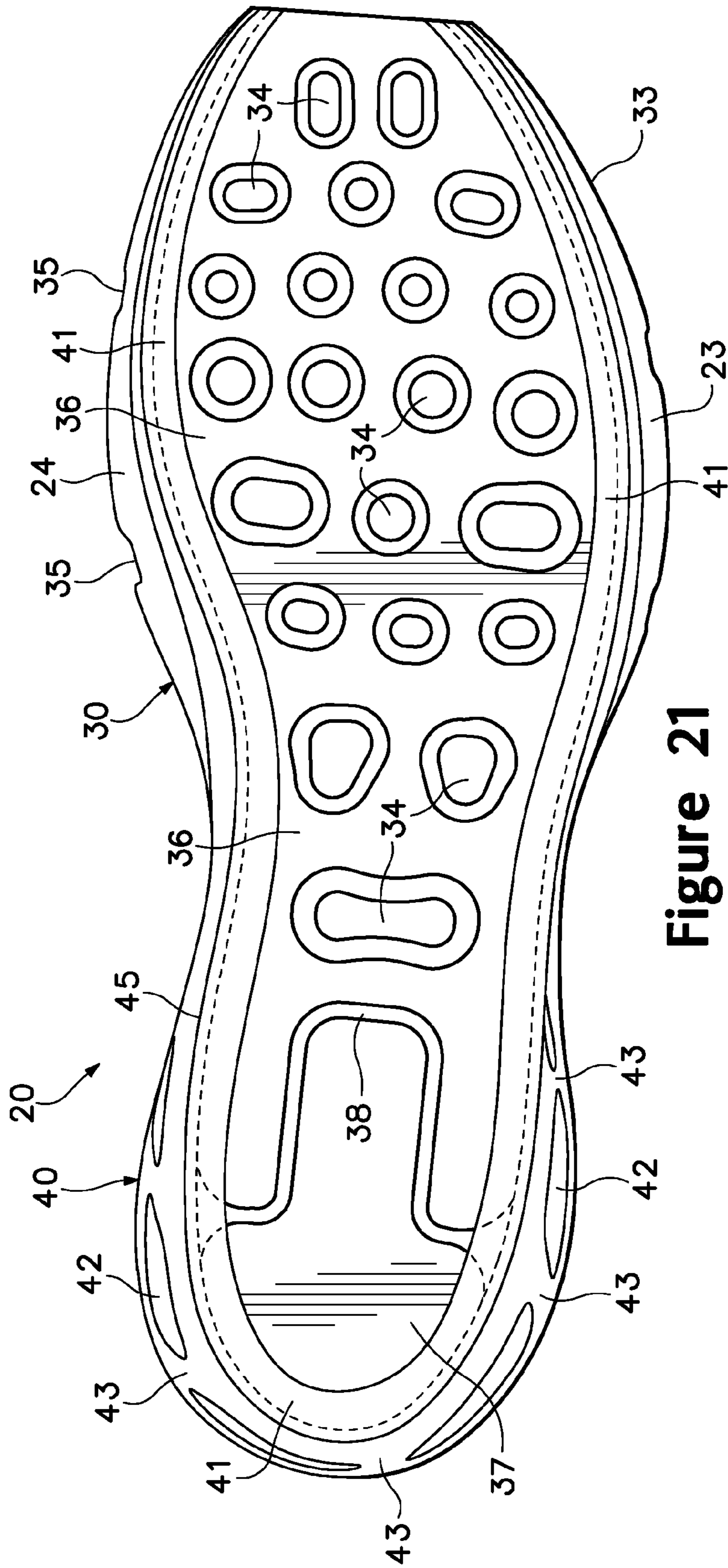


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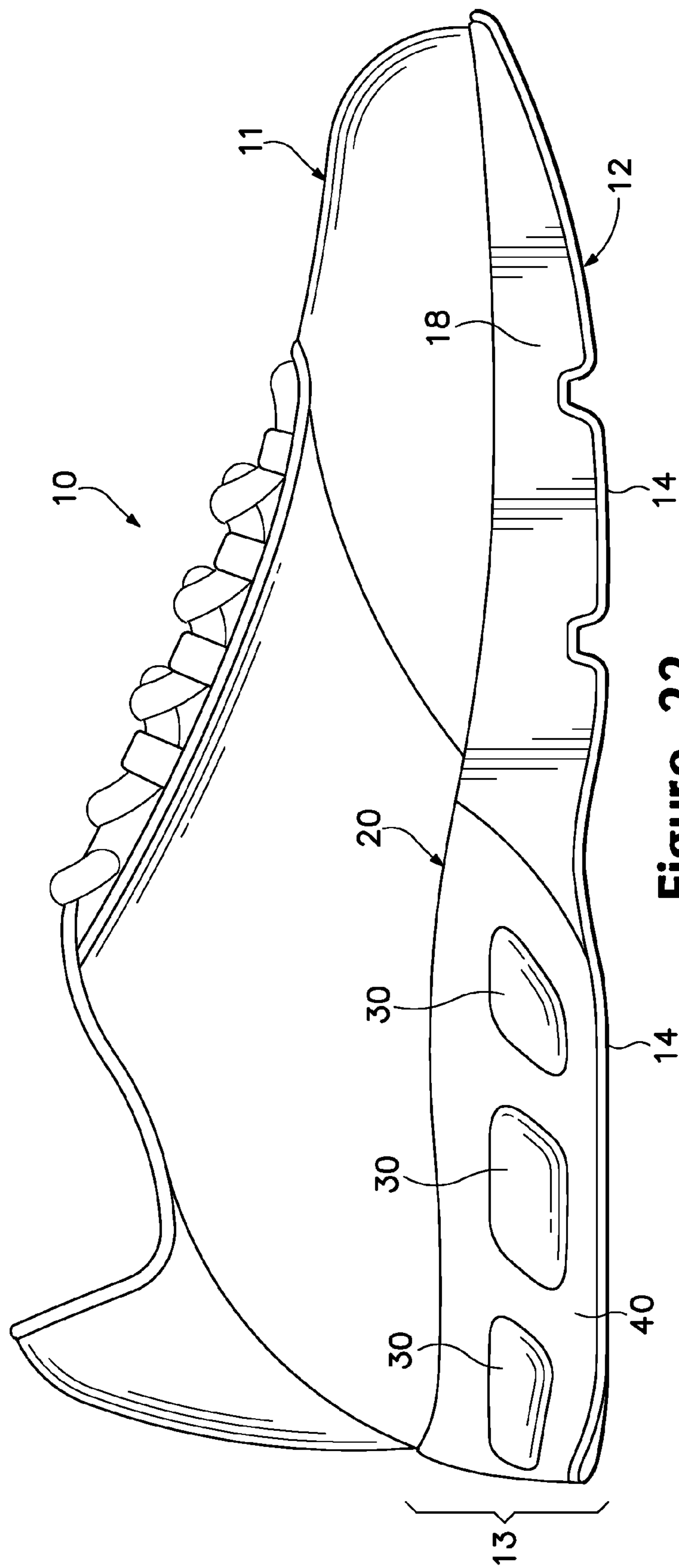


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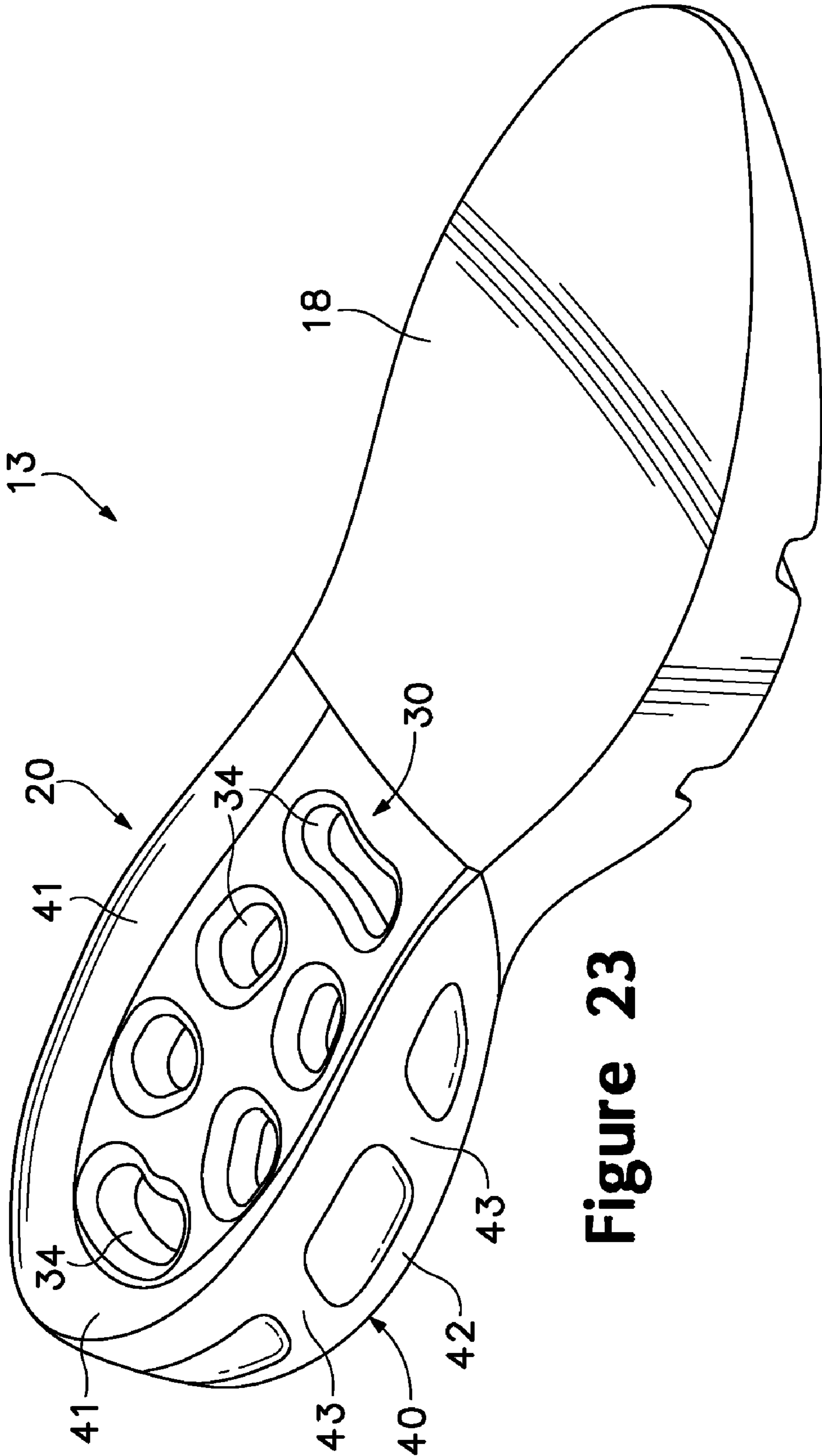


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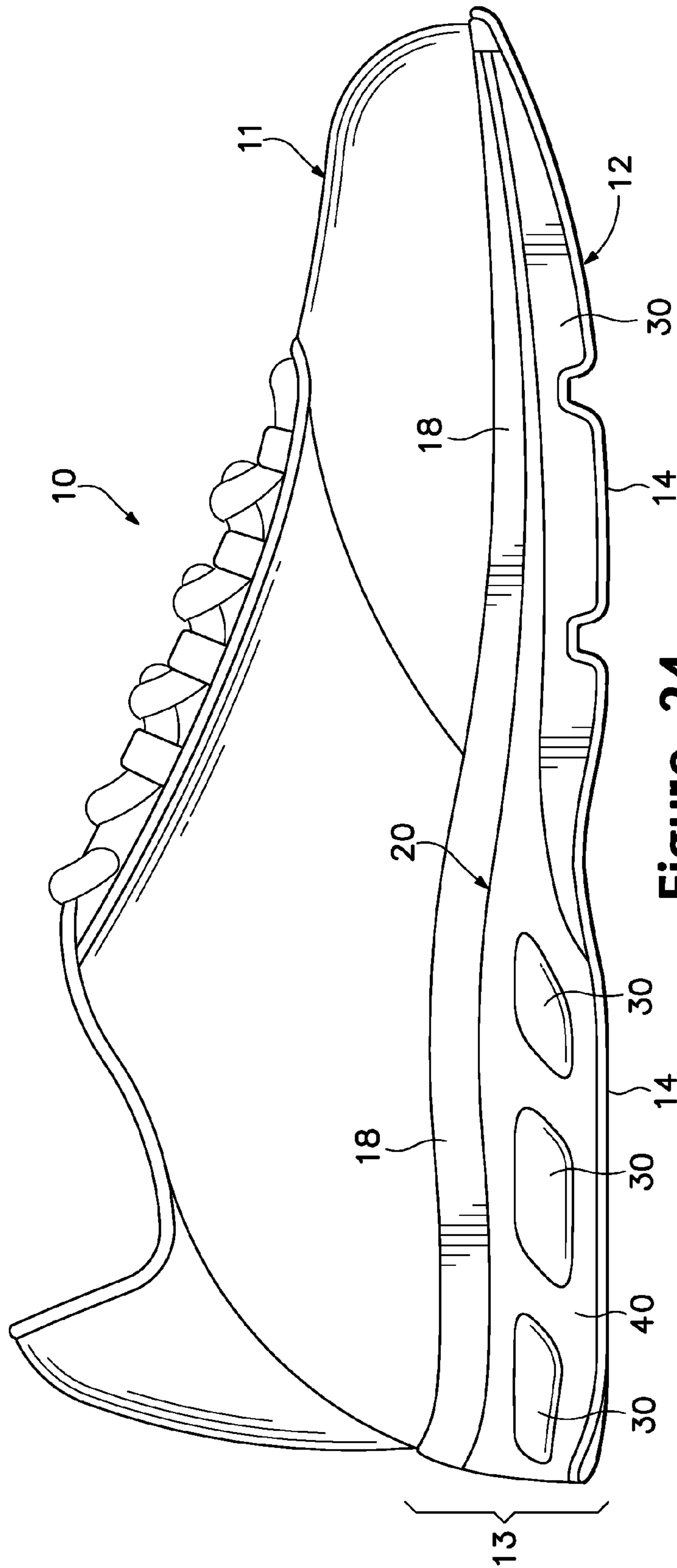


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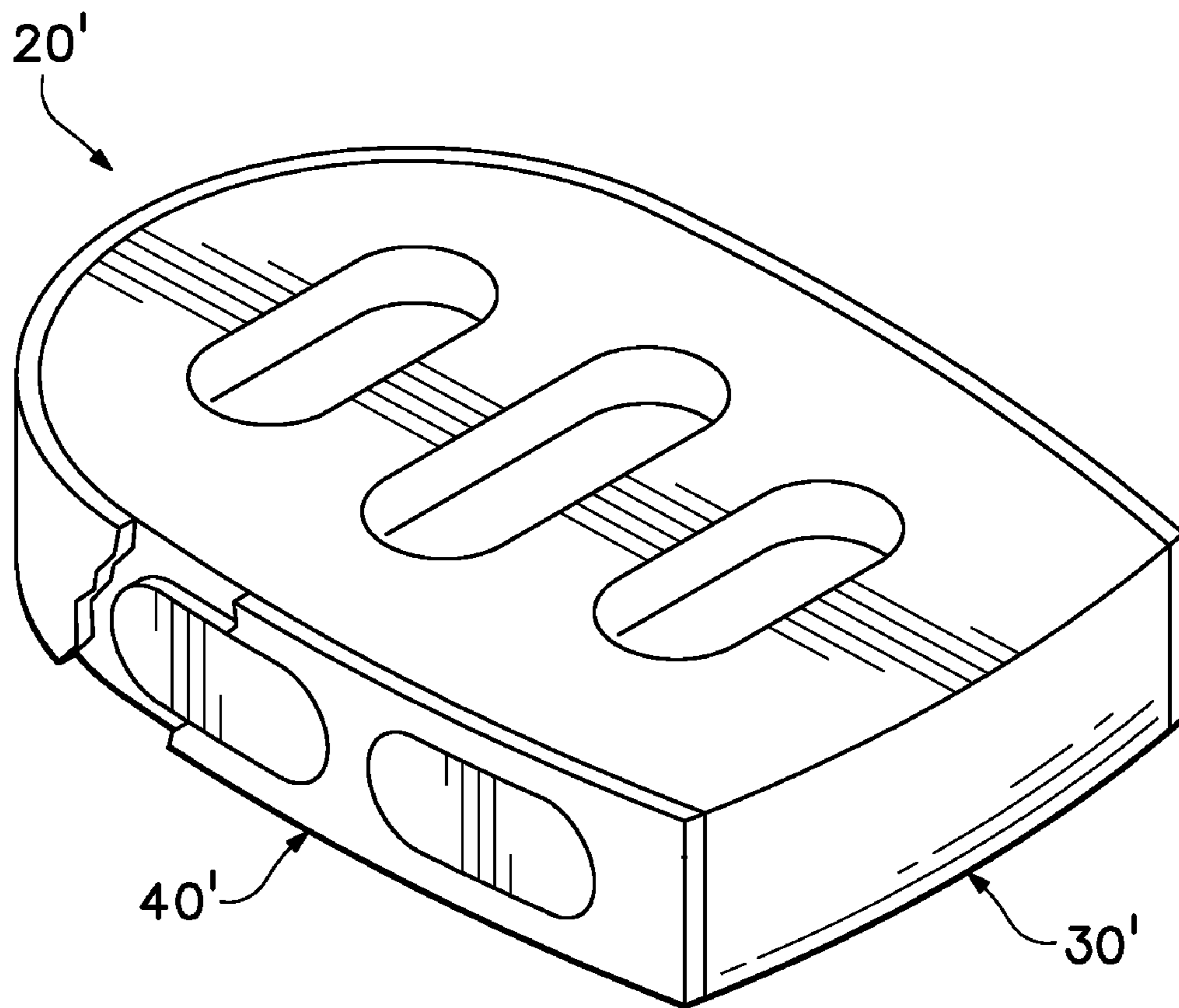


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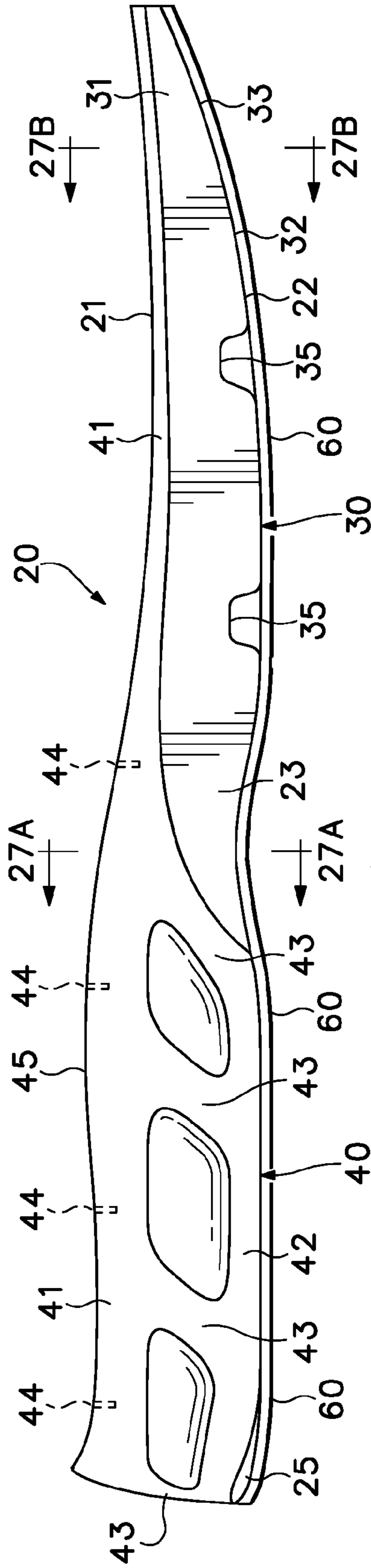


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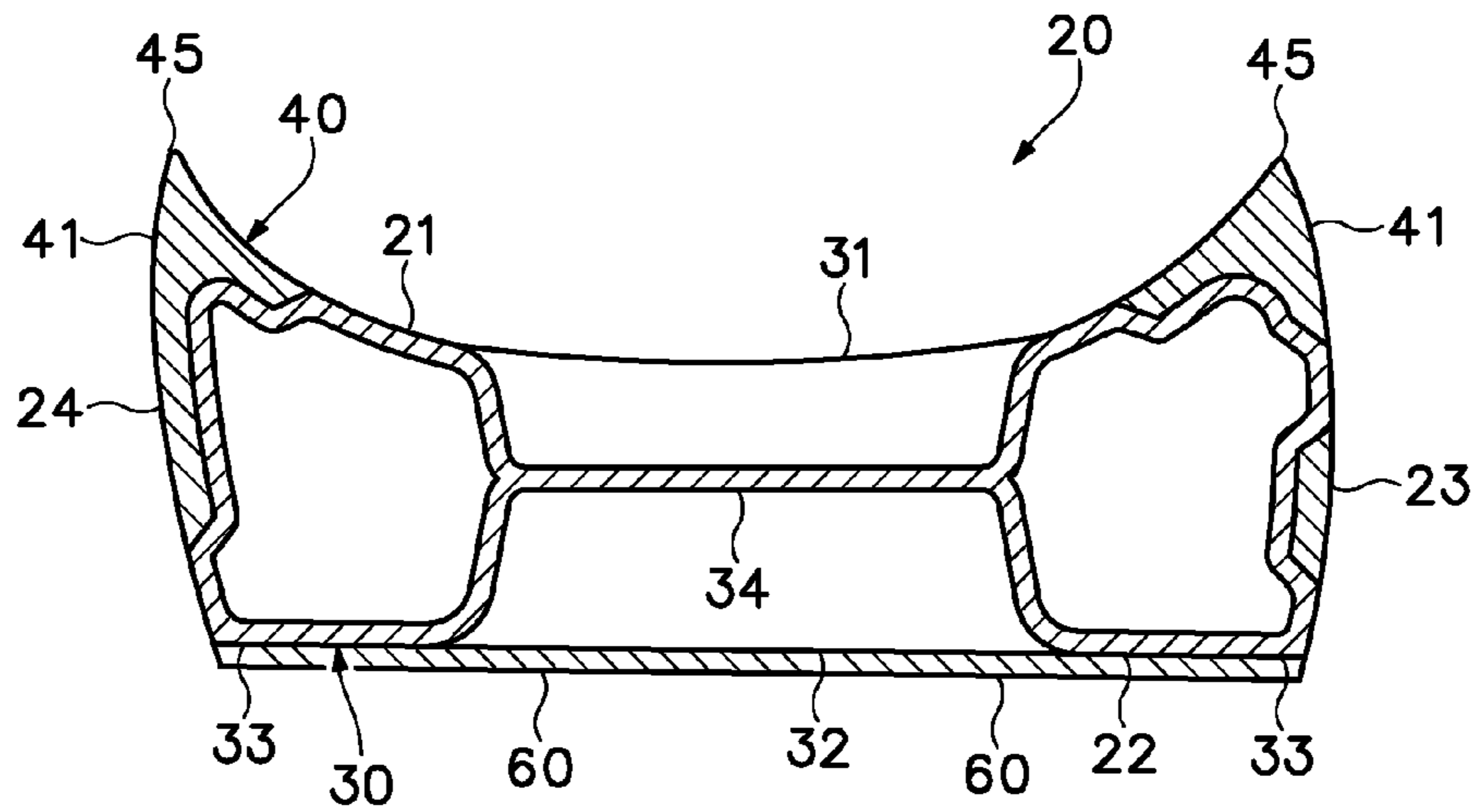


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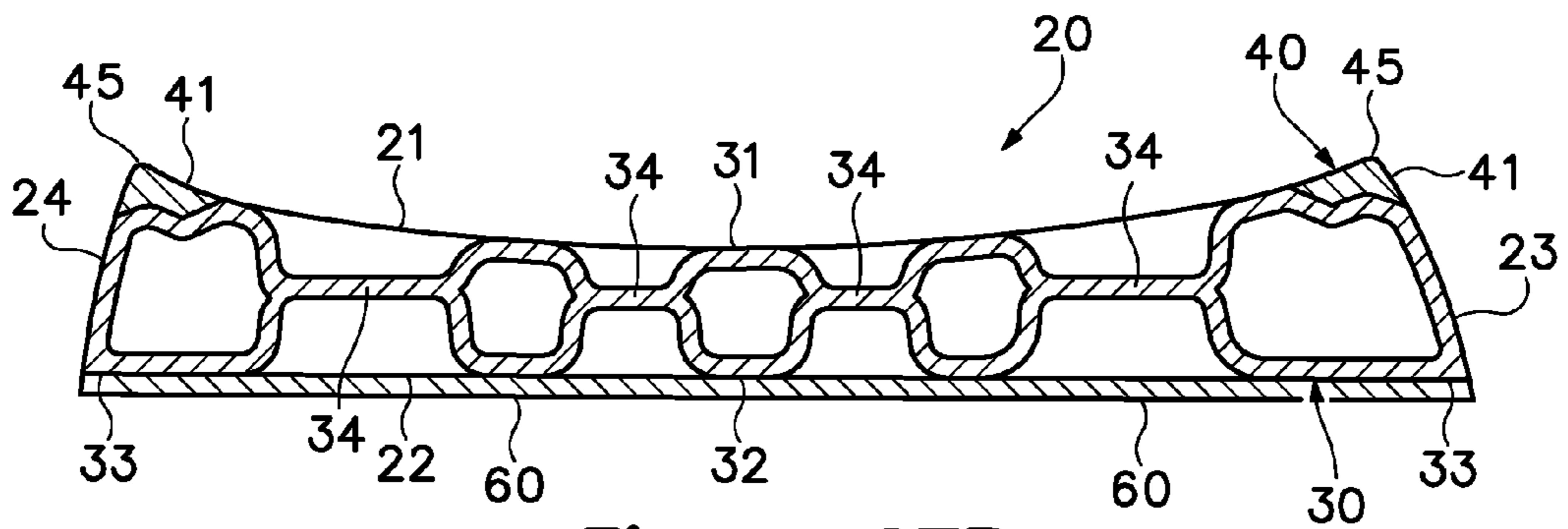


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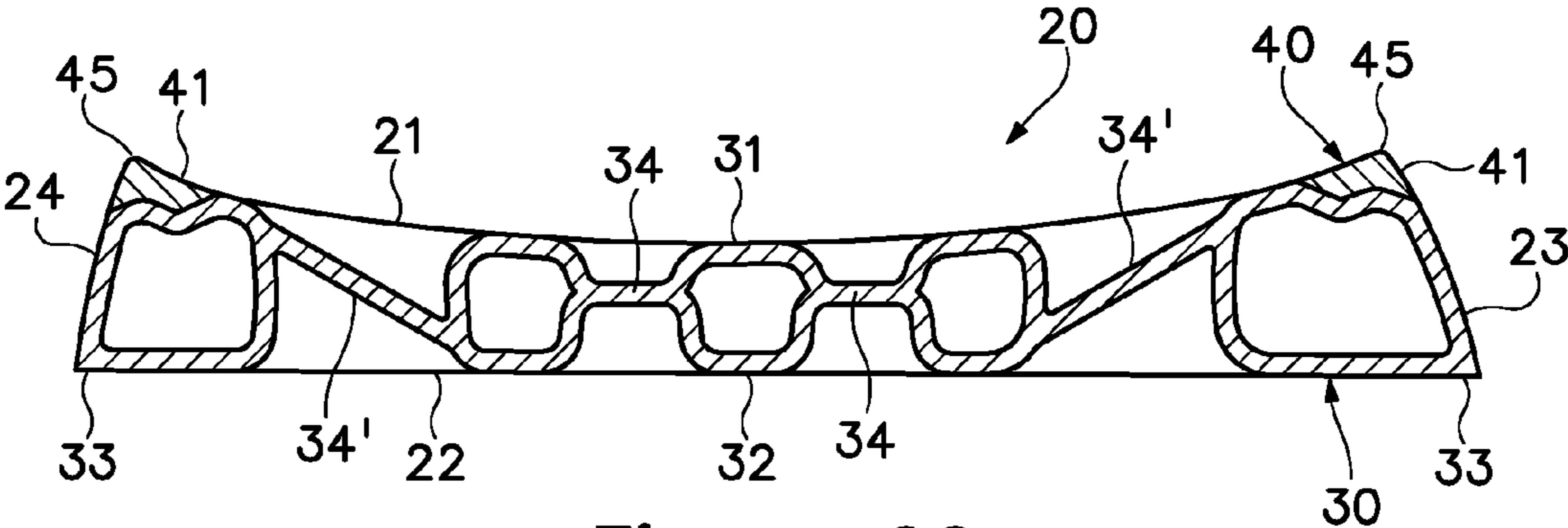


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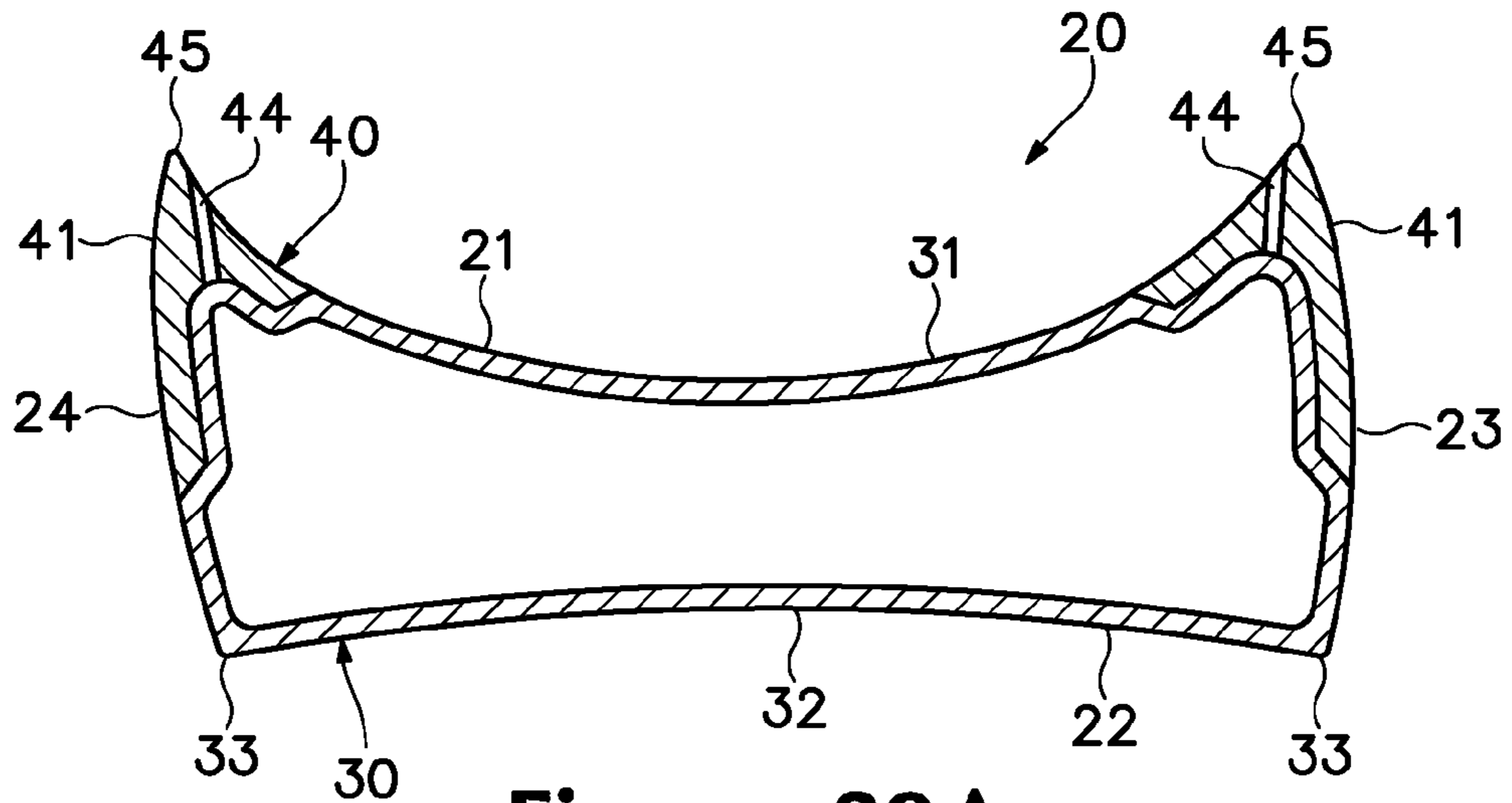


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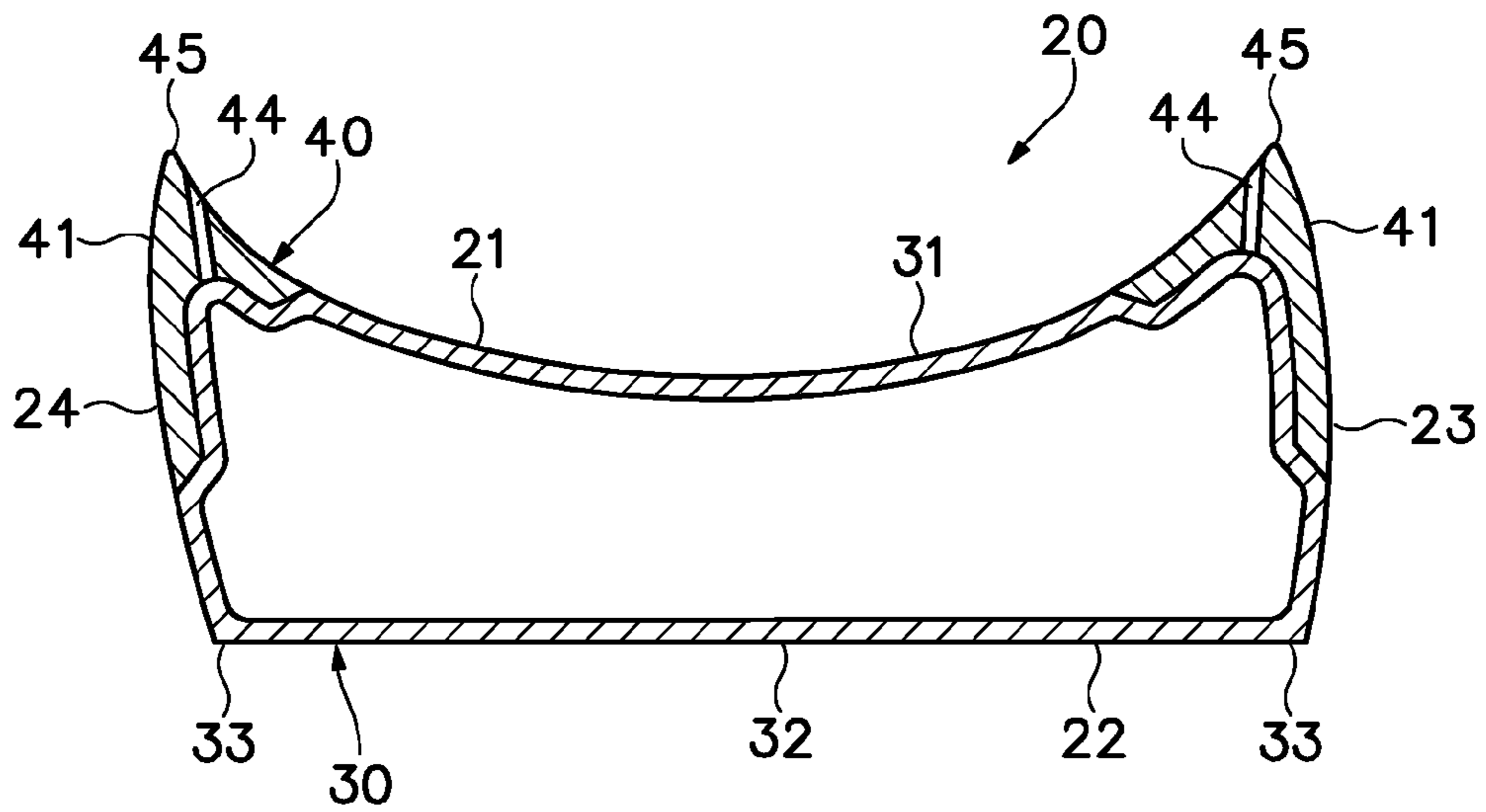


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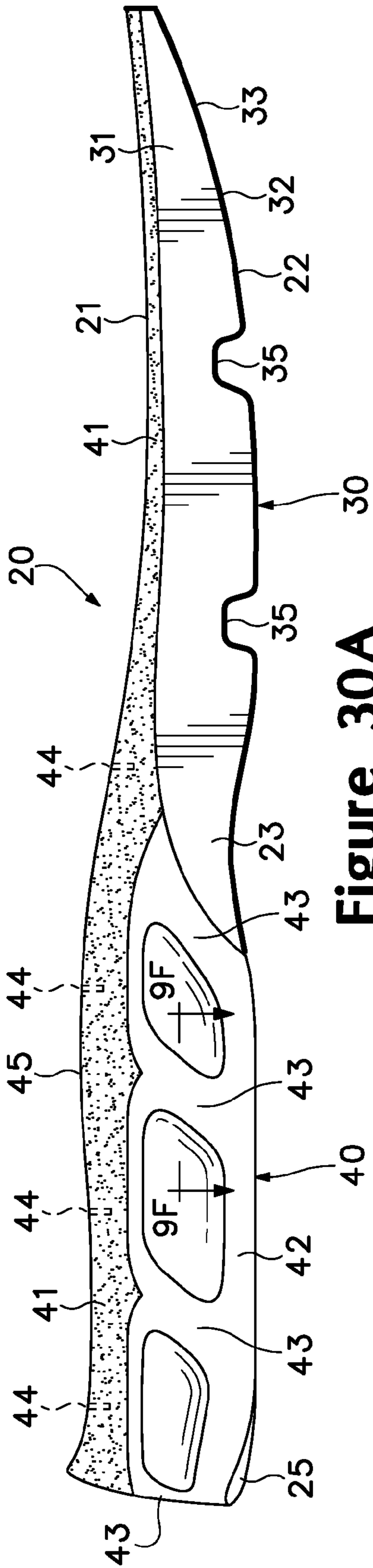


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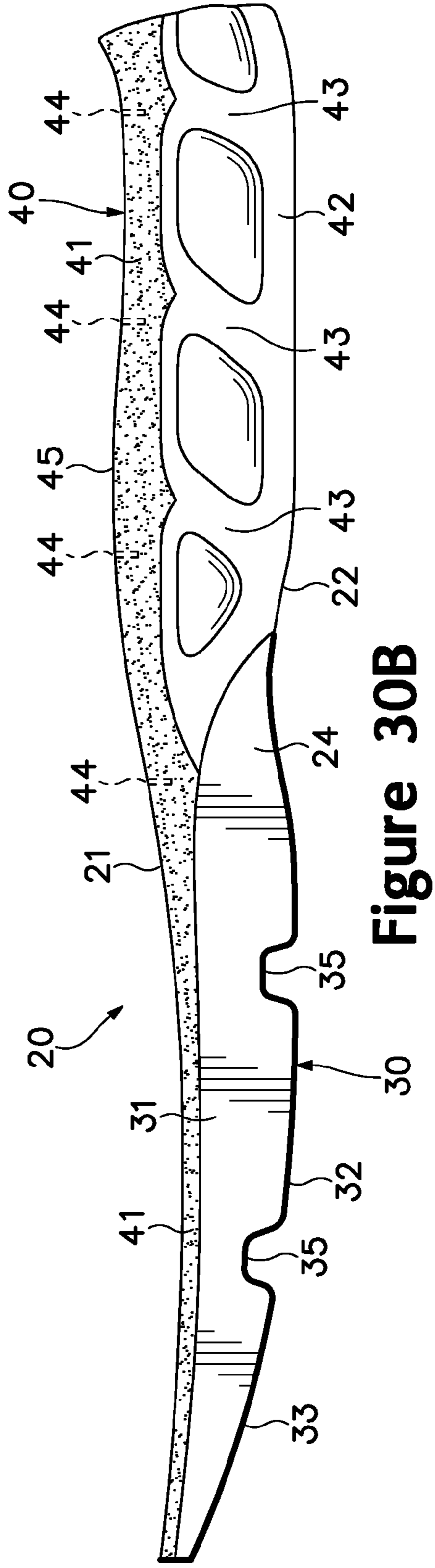


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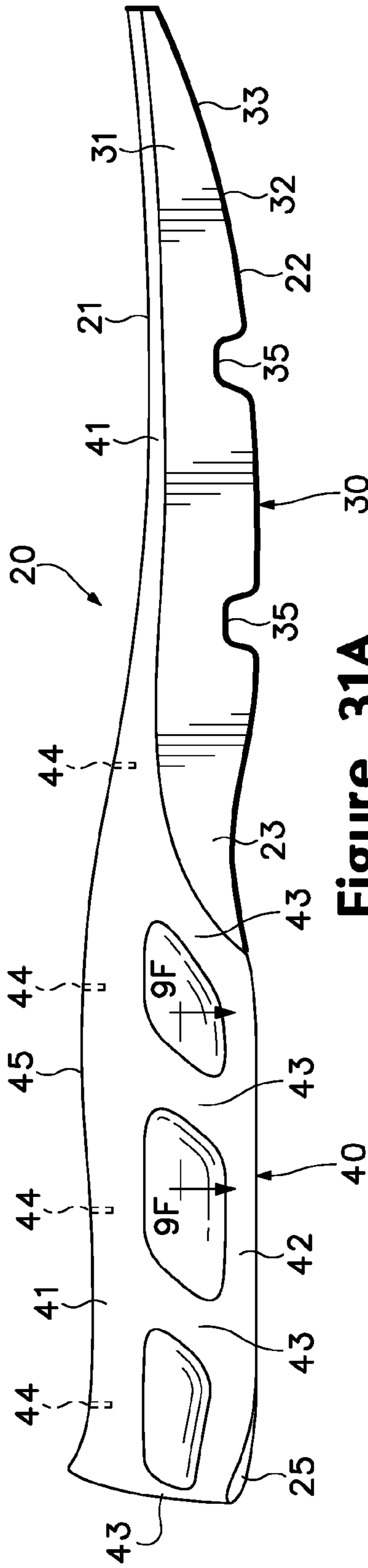


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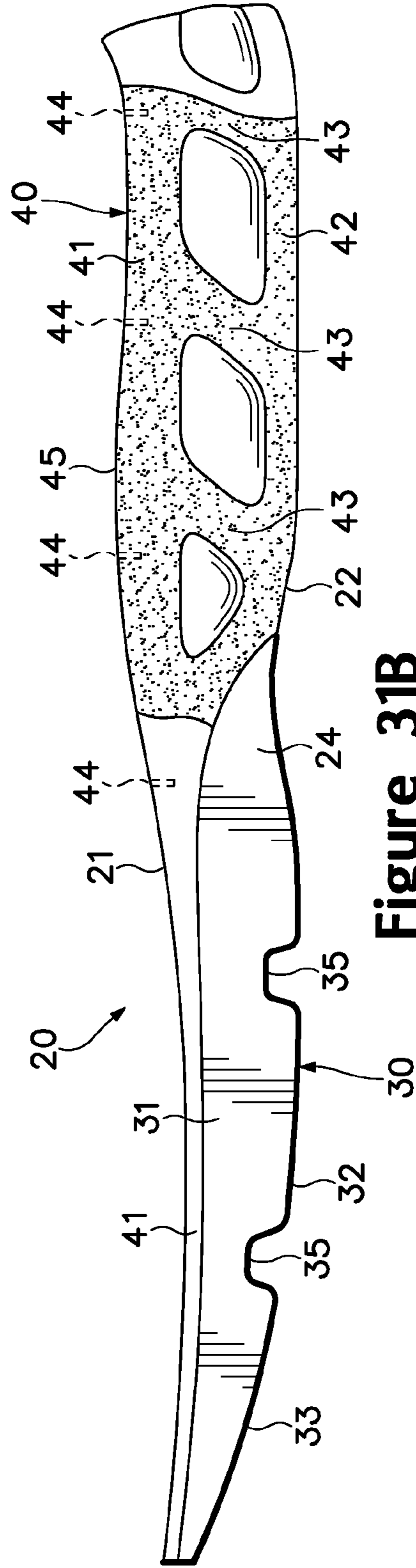


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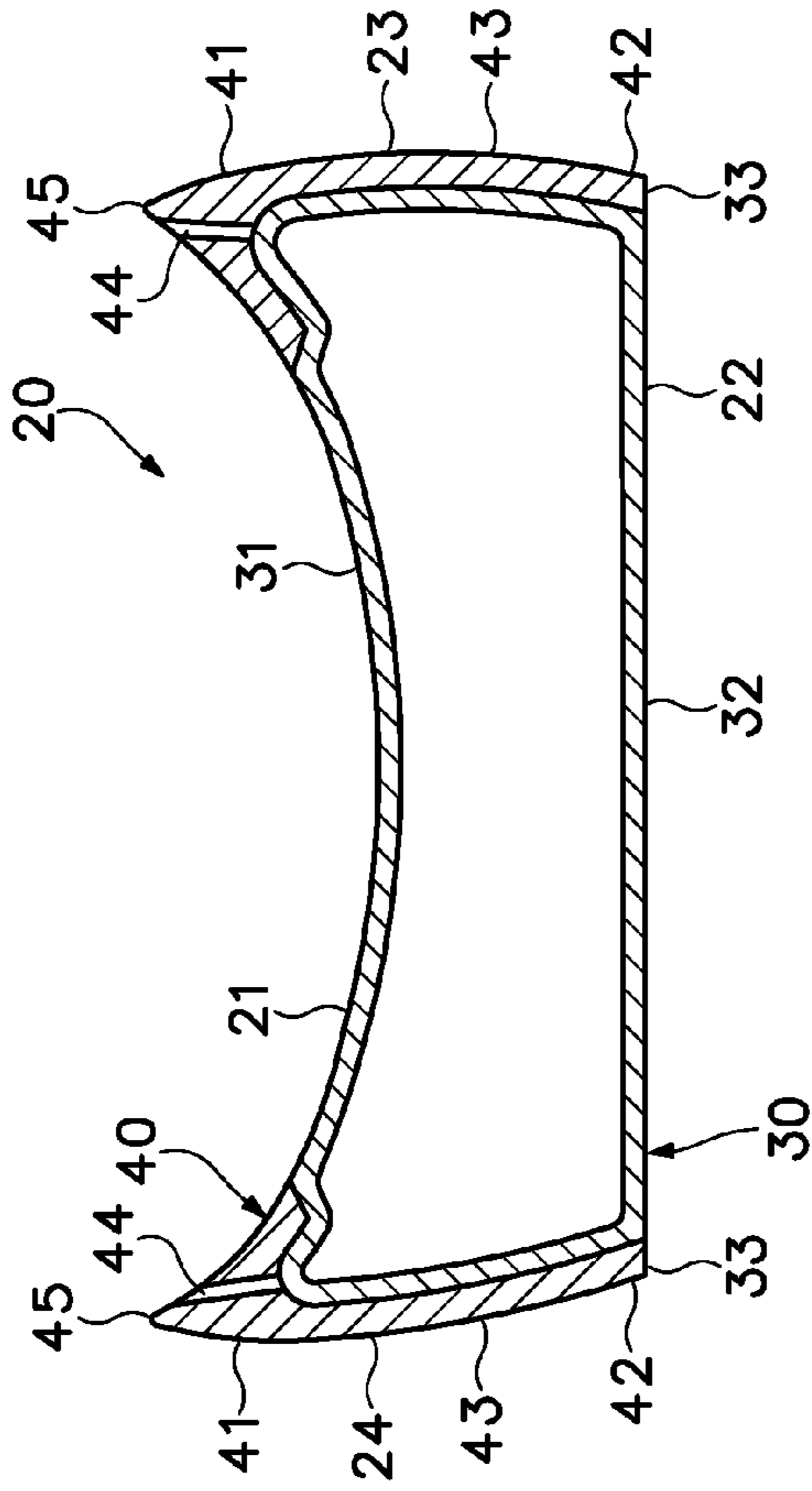


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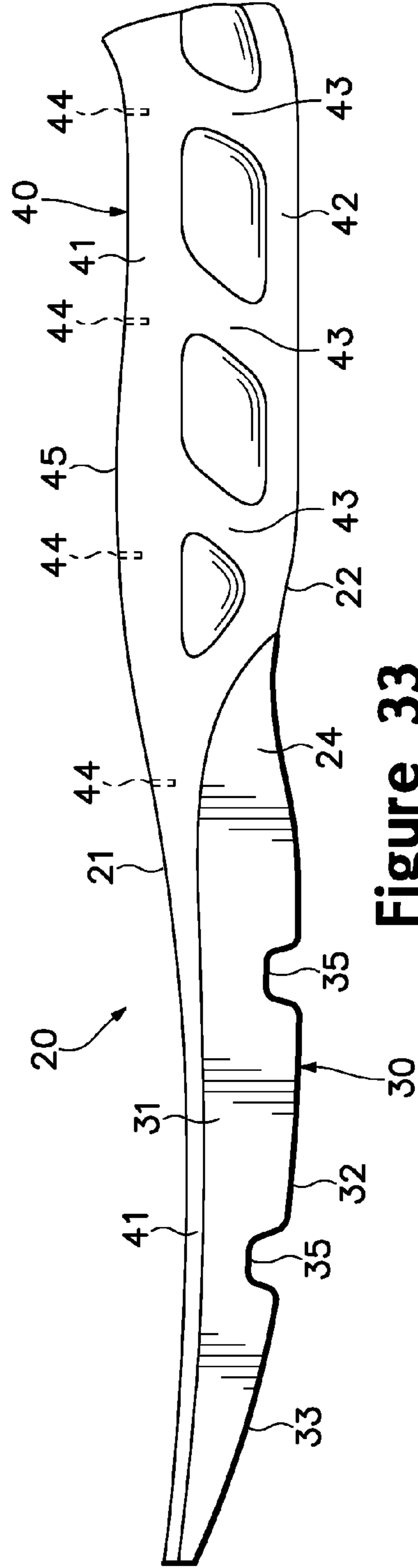


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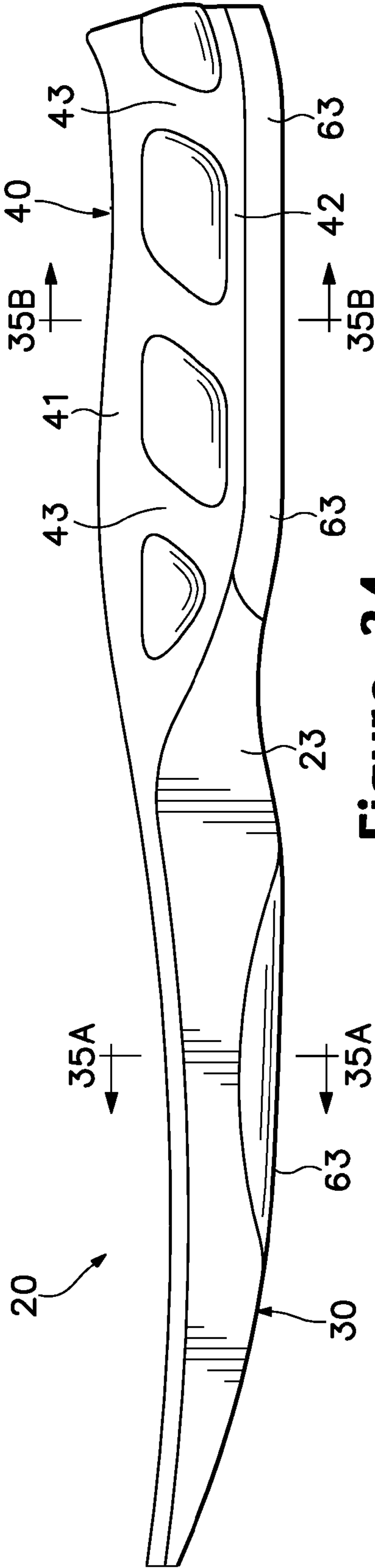


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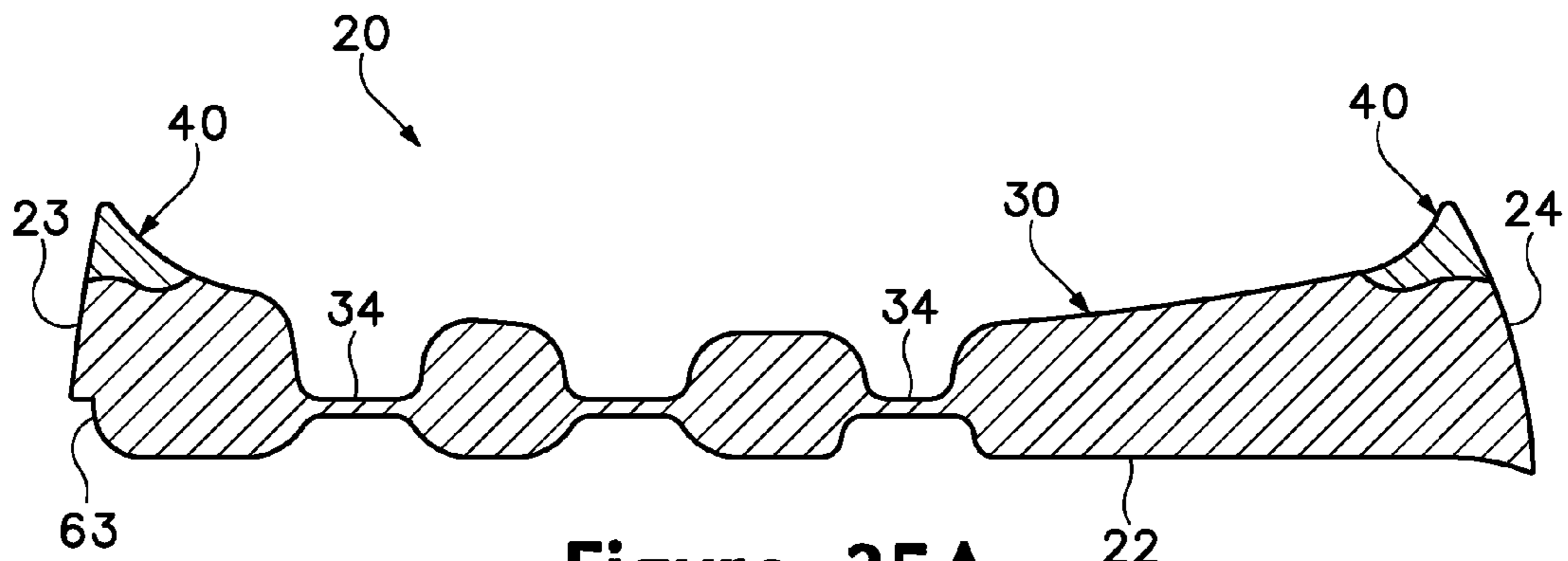


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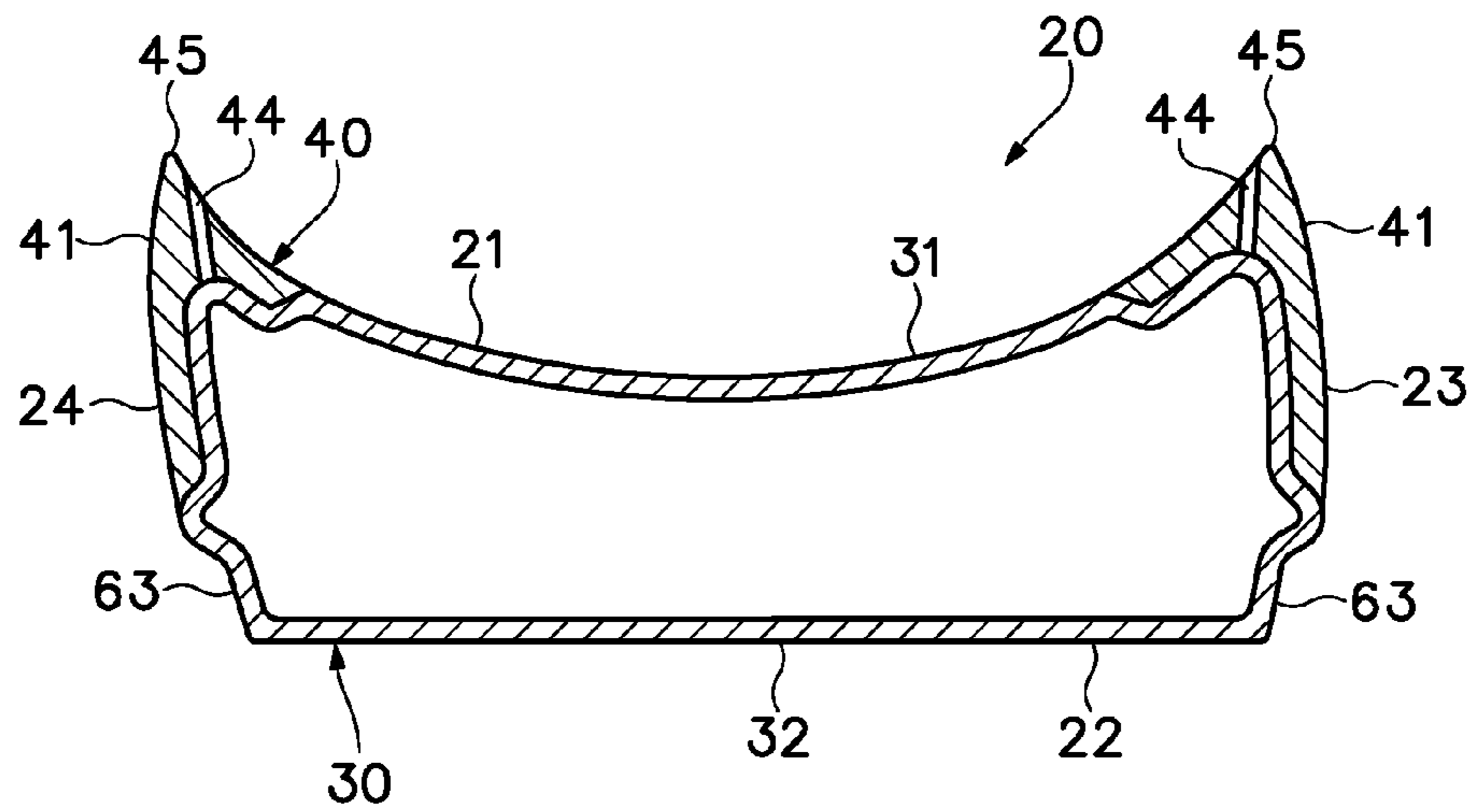


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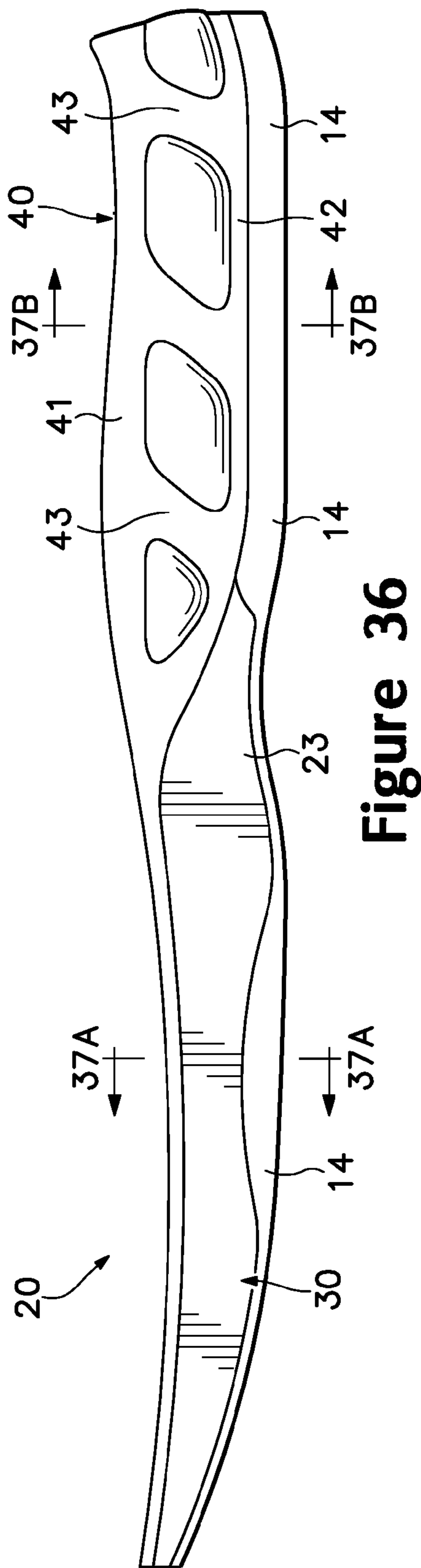


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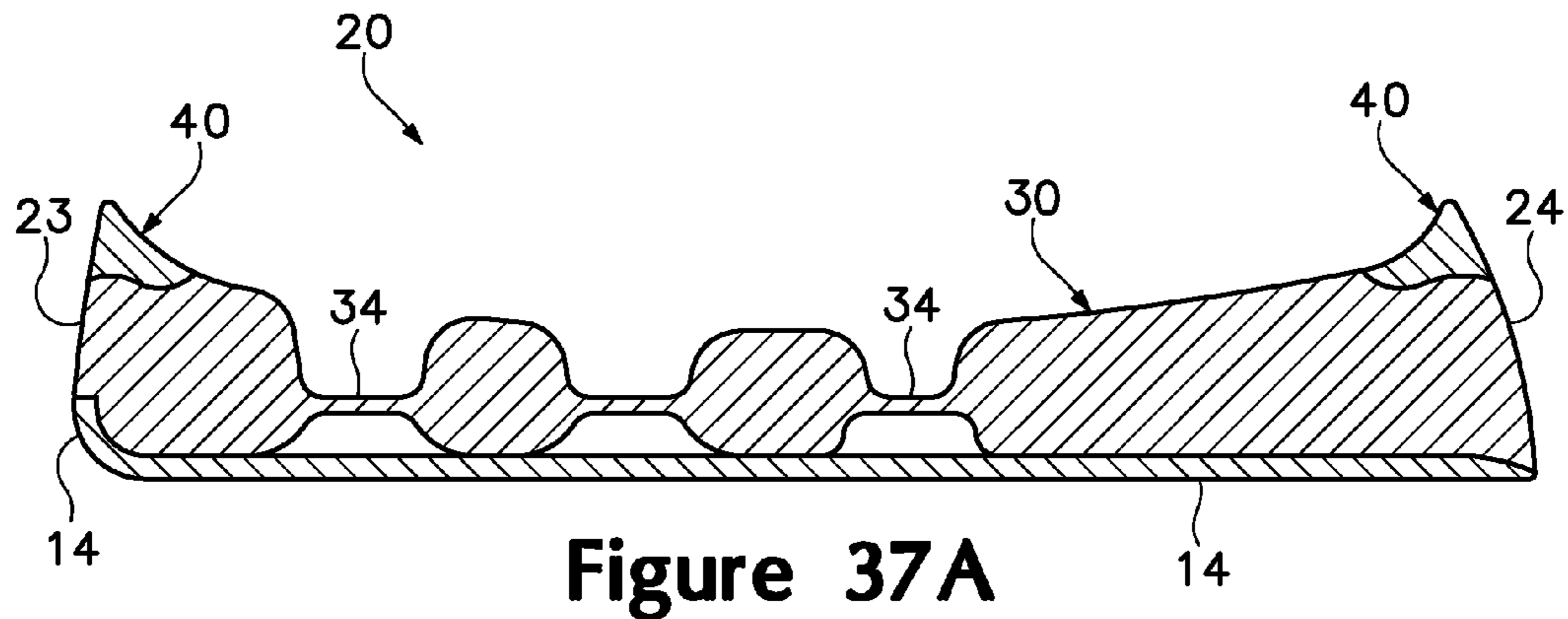


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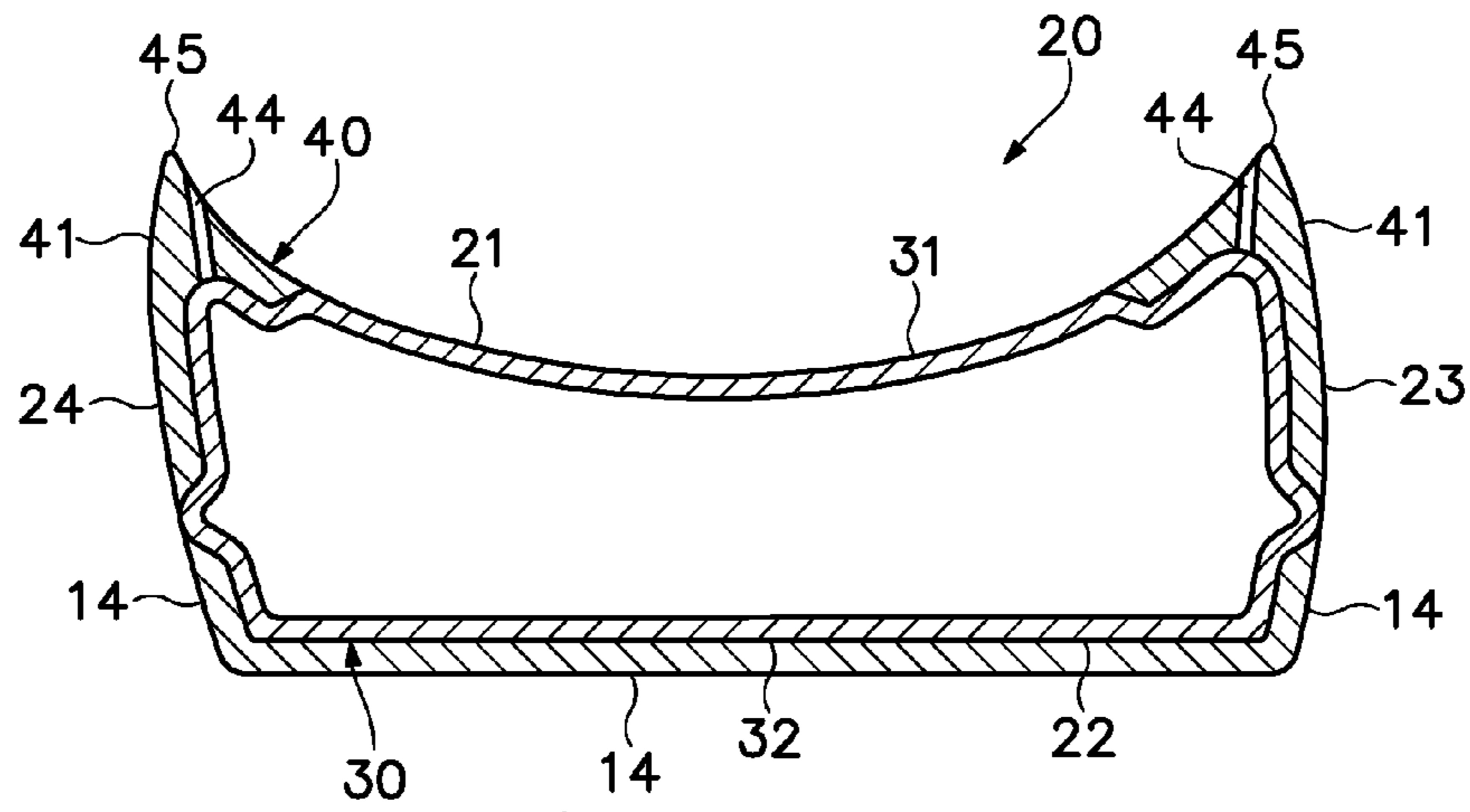


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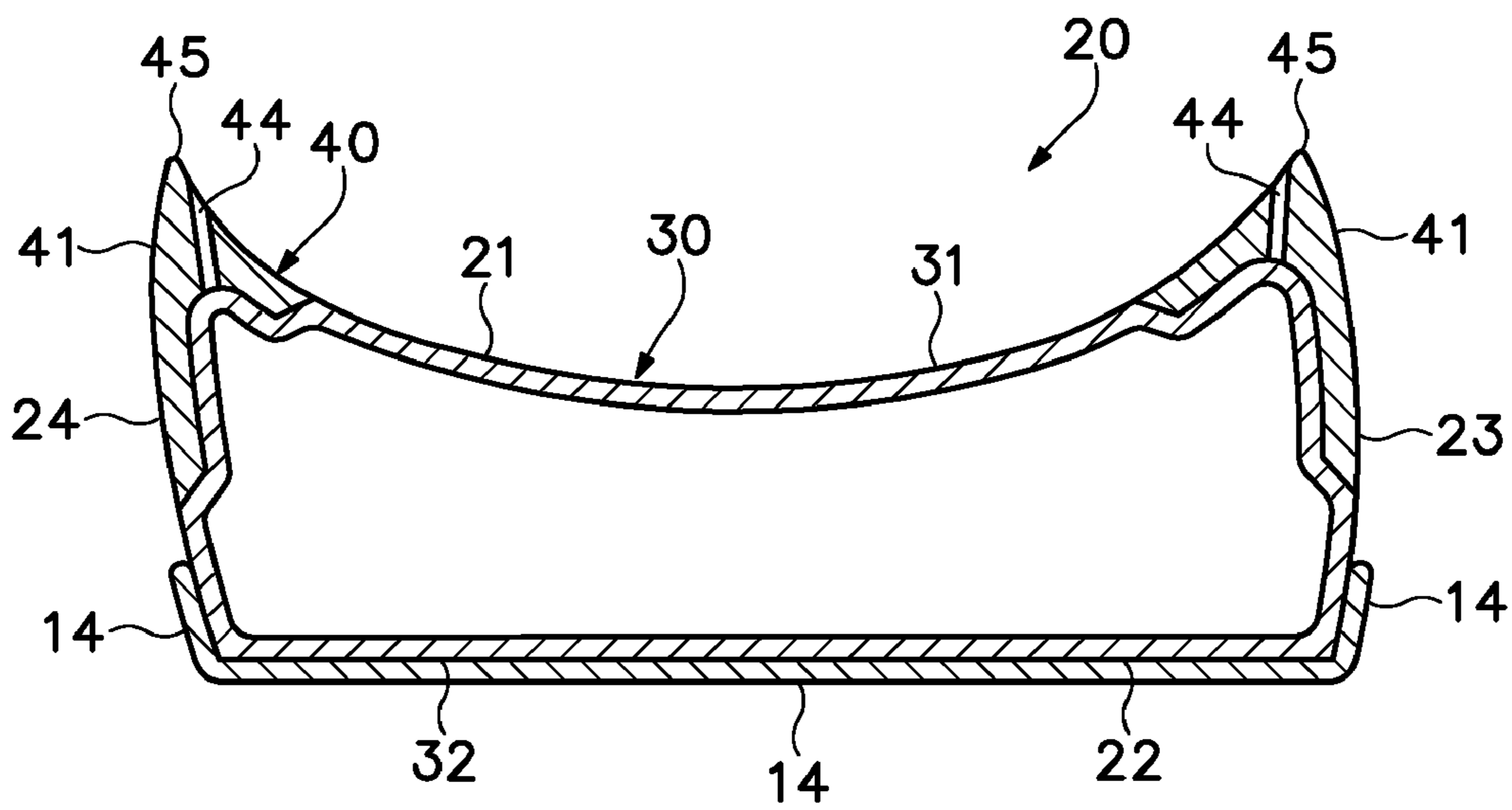


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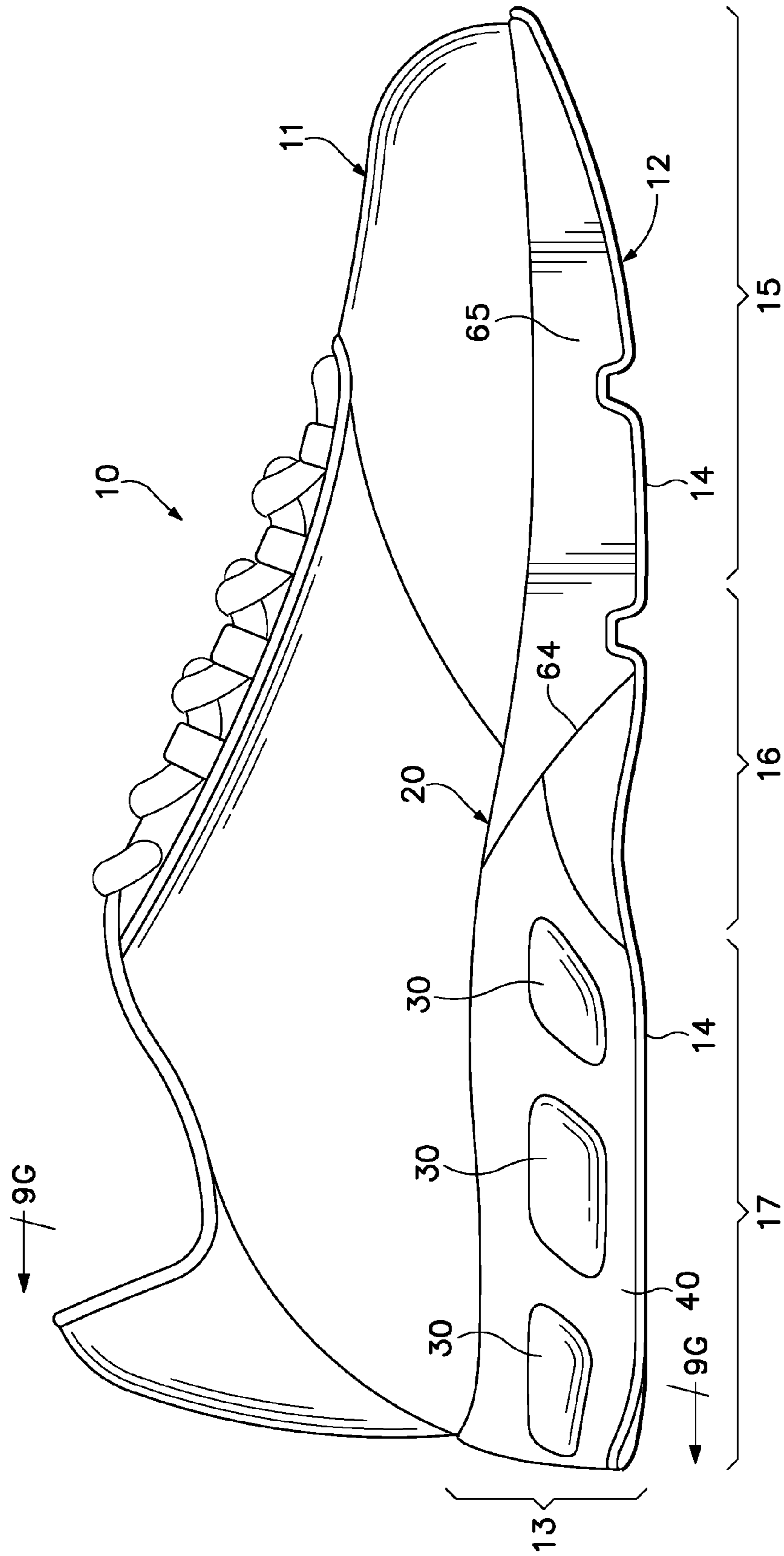


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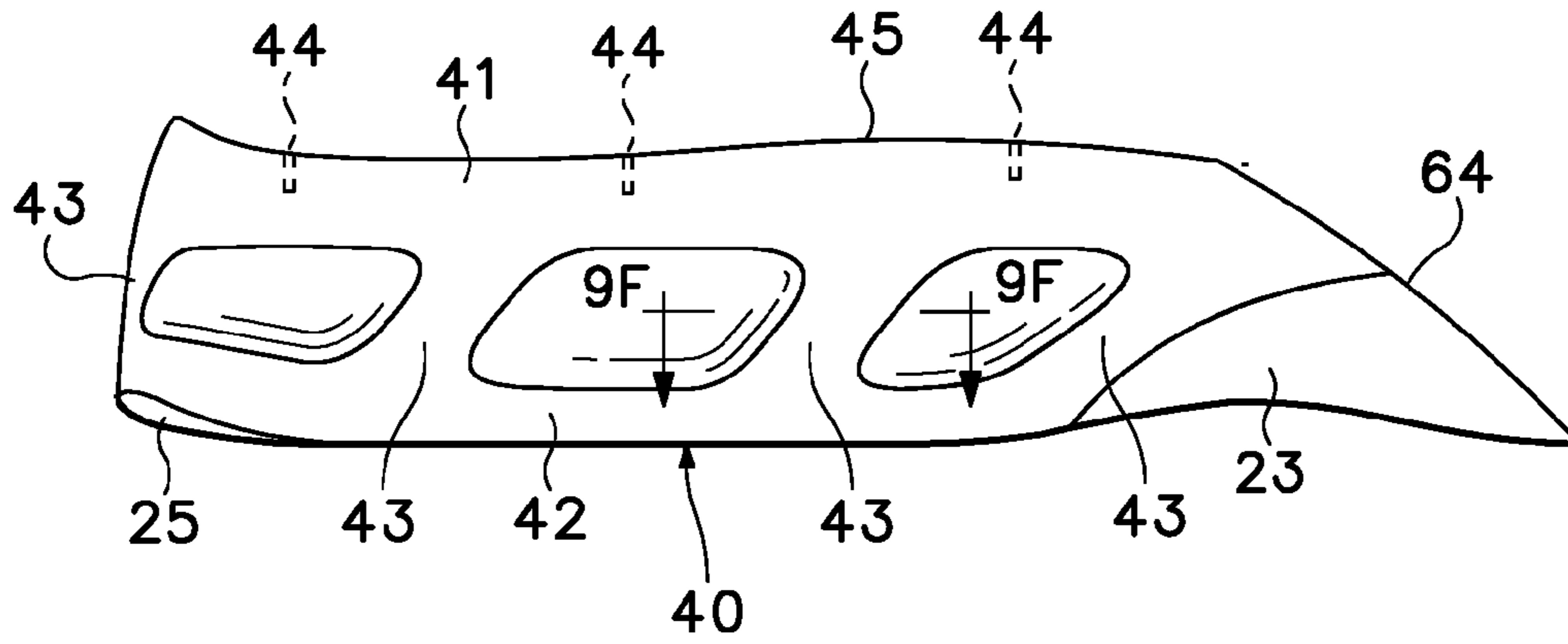


Figure 39A

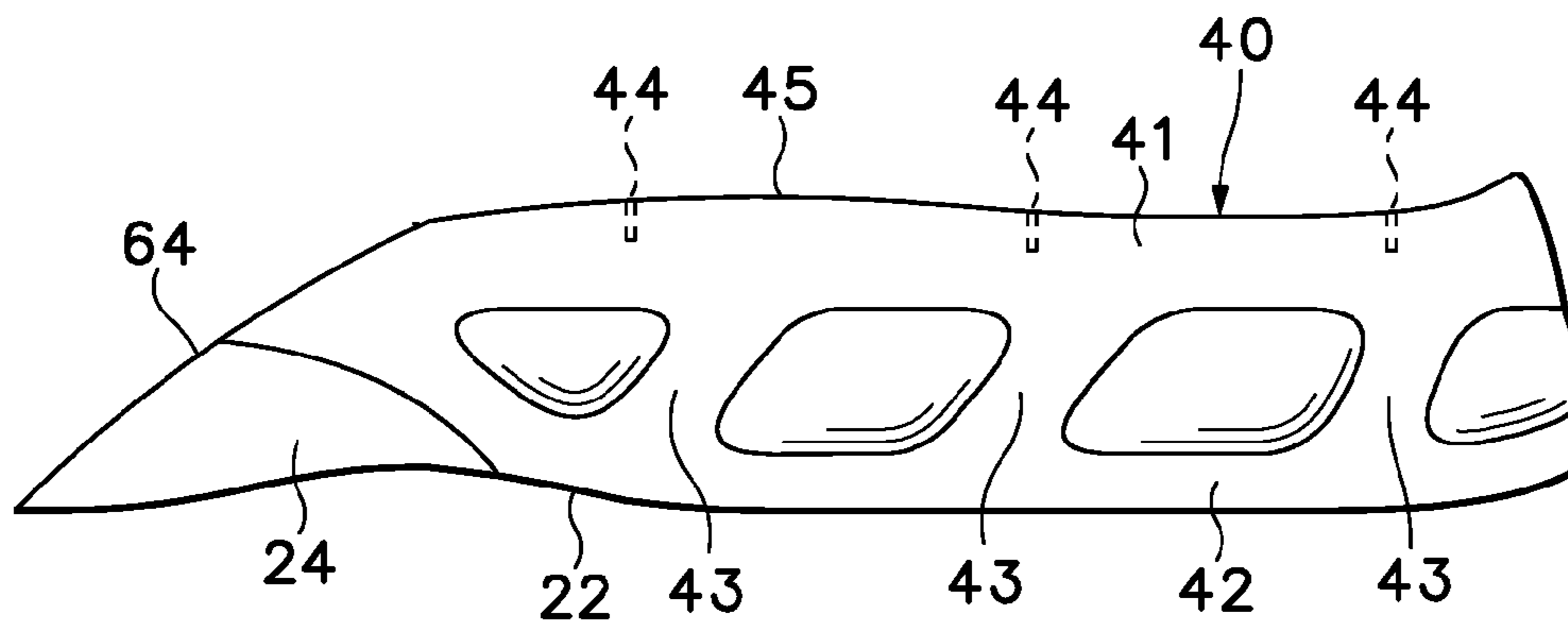


Figure 39B

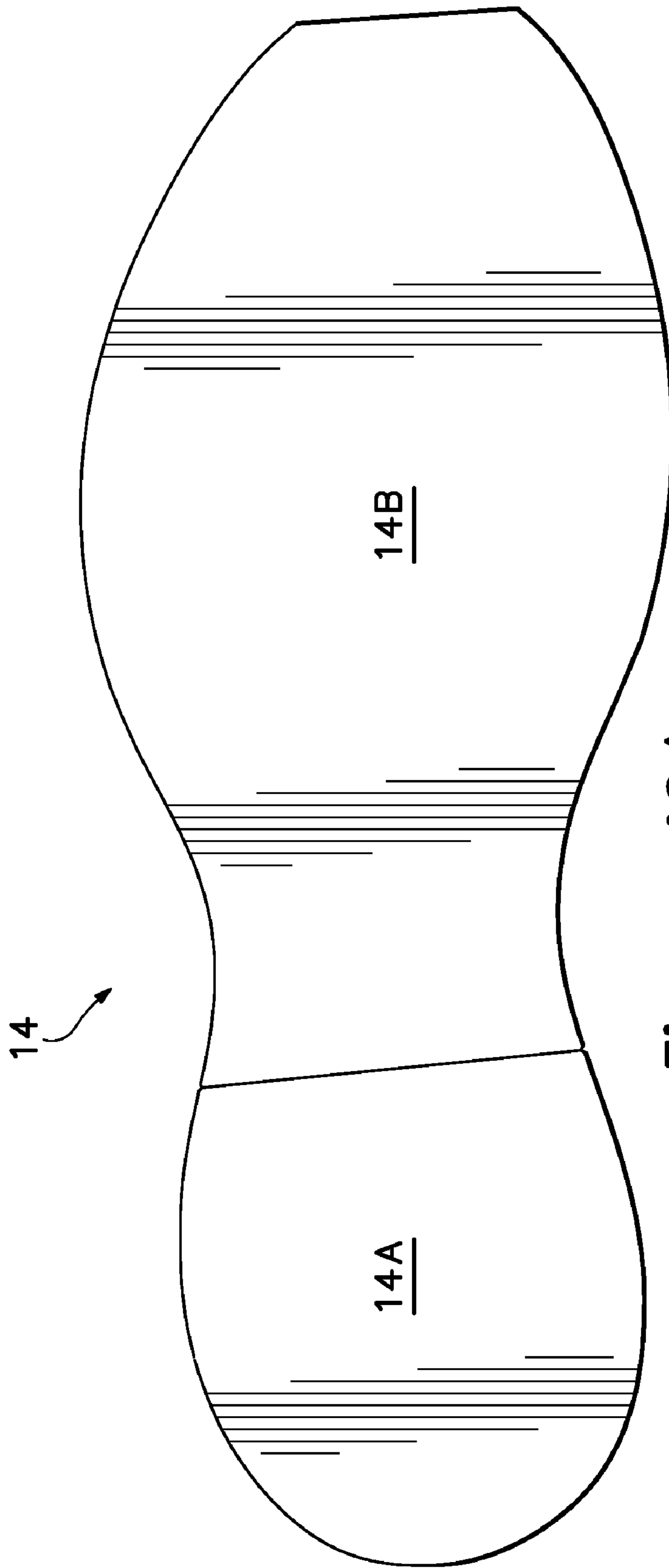


Figure 40A

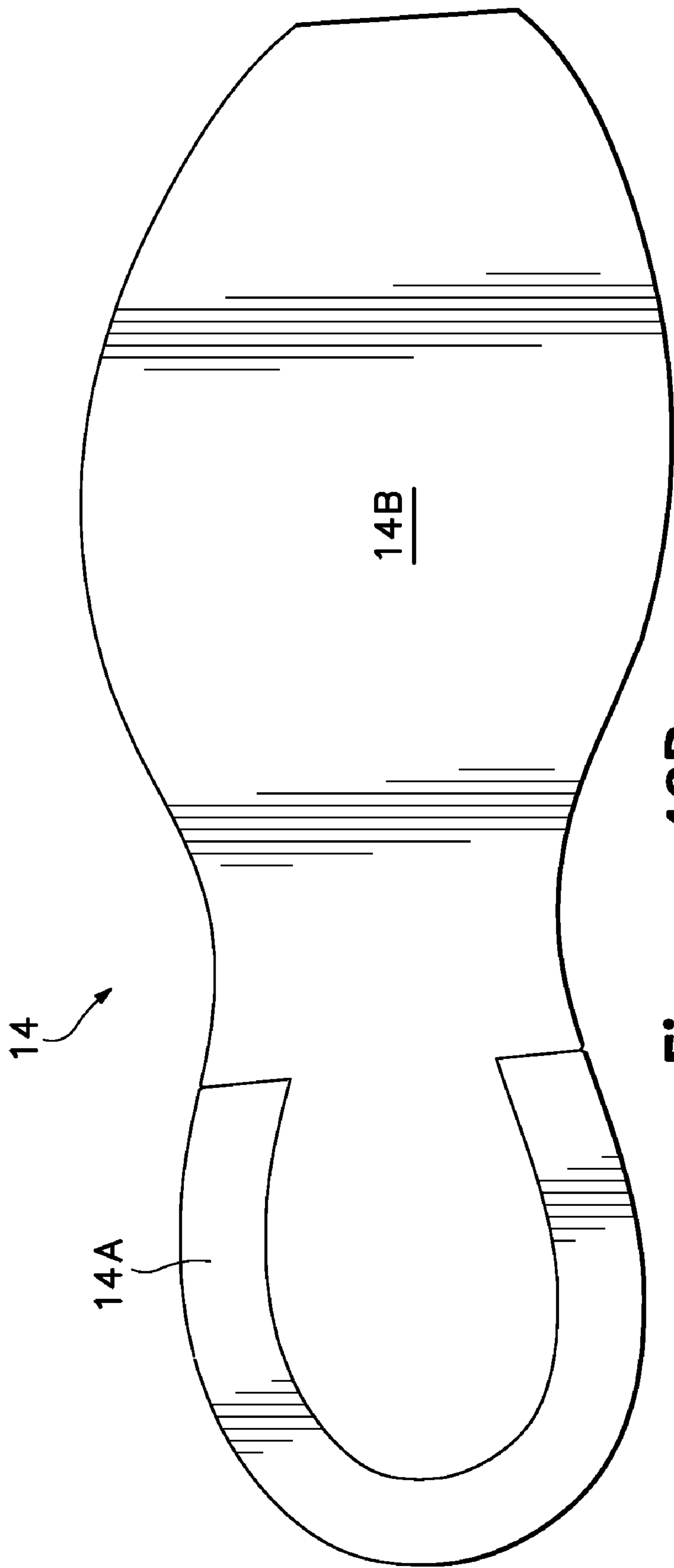


Figure 40B

**ARTICLE OF FOOTWEAR HAVING A
FLUID-FILLED BLADDER WITH A
REINFORCING STRUCTURE**

CROSS-REFERENCE TO RELATED
APPLICATIONS

This non-provisional U.S. patent application is a divisional application of and claims priority to non-provisional U.S. patent application Ser. No. 11/251,622, which was filed in the U.S. Patent and Trademark Office on 14 Oct. 2005 and entitled Article Of Footwear Having A Fluid-Filled Bladder With A Reinforcing Structure, such non-provisional U.S. patent application being entirely incorporated herein by reference. Non-provisional U.S. patent application Ser. No. 11/251,622 is a continuation-in-part application of and claims priority to non-provisional U.S. patent application Ser. No. 10/767,211 (issued as U.S. Pat. No. 7,086,179 on 8 Aug. 2006), which was filed in the U.S. Patent and Trademark Office on 28 Jan. 2004 and entitled Article Of Footwear Having A Fluid-Filled Bladder With A Reinforcing Structure, such non-provisional U.S. patent application being entirely incorporated herein by reference. In turn, non-provisional U.S. patent application Ser. No. 10/767,211 claims priority to provisional U.S. Patent Application Ser. No. 60/531,674, which was filed in the U.S. Patent and Trademark Office on 23 Dec. 2003 and entitled Article Of Footwear Having A Fluid-Filled Bladder With A Reinforcing Structure, such provisional U.S. patent application being entirely incorporated herein by reference.

BACKGROUND OF THE INVENTION

1. Field of the Invention

The present invention relates to footwear. The invention concerns, more particularly, a sole component for an article of footwear and a method of manufacturing the sole component. Although the configuration of the sole component may vary significantly within the scope of the present invention, the sole component generally includes a fluid-filled bladder and an external reinforcing structure secured to the bladder.

2. Description of Background Art

A conventional article of athletic footwear includes two primary elements, an upper and a sole structure. The upper provides a covering for the foot that securely receives and positions the foot with respect to the sole structure. In addition, the upper may have a configuration that protects the foot and provides ventilation, thereby cooling the foot and removing perspiration. The sole structure is secured to a lower surface of the upper and is generally positioned between the foot and the ground. In addition to attenuating ground reaction forces, the sole structure may provide traction and control foot motions, such as over pronation. Accordingly, the upper and the sole structure operate cooperatively to provide a comfortable structure that is suited for a wide variety of ambulatory activities, such as walking and running.

The sole structure of athletic footwear generally exhibits a layered configuration that includes a comfort-enhancing insole, a resilient midsole formed from a polymer foam, and a ground-contacting outsole that provides both abrasion-resistance and traction. Suitable polymer foam materials for the midsole include ethylvinylacetate or polyurethane that compress resiliently under an applied load to attenuate ground reaction forces and absorb energy. Conventional polymer foam materials are resiliently compressible, in part, due to the inclusion of a plurality of open or closed cells that define an inner volume substantially displaced by gas. That is, the poly-

mer foam includes a plurality of bubbles that enclose the gas. Following repeated compressions, the cell structure may deteriorate, thereby resulting in decreased compressibility of the foam. Accordingly, the force attenuation and energy absorption characteristics of the midsole may decrease over the lifespan of the footwear.

One manner of reducing the weight of a polymer foam midsole and decreasing the effects of deterioration following repeated compressions is disclosed in U.S. Pat. No. 4,183,156 to Rudy, hereby incorporated by reference, in which ground reaction force attenuation is provided by a fluid-filled bladder formed of an elastomeric materials. The bladder includes a plurality of tubular chambers that extend longitudinally along a length of the sole structure. The chambers are in fluid communication with each other and jointly extend across the width of the footwear. The bladder may be encapsulated in a polymer foam material, as disclosed in U.S. Pat. No. 4,219,945 to Rudy, hereby incorporated by reference. The combination of the bladder and the encapsulating polymer foam material functions as a midsole. Accordingly, the upper is attached to the upper surface of the polymer foam material and an outsole or tread member is affixed to the lower surface.

Bladders of the type discussed above are generally formed of an elastomeric material and are structured to have an upper and lower portions that enclose one or more chambers therebetween. The chambers are pressurized above ambient pressure by inserting a nozzle or needle connected to a fluid pressure source into a fill inlet formed in the bladder. Following pressurization of the chambers, the fill inlet is sealed and the nozzle is removed.

Fluid-filled bladders suitable for footwear applications may be manufactured by a two-film technique, in which two separate sheets of elastomeric film are formed to exhibit the overall peripheral shape of the bladder. The sheets are then bonded together along their respective peripheries to form a sealed structure, and the sheets are also bonded together at predetermined interior areas to give the bladder a desired configuration. That is, the interior bonds provide the bladder with chambers having a predetermined shape and size. Such bladders have also been manufactured by a blow-molding technique, wherein a molten or otherwise softened elastomeric material in the shape of a tube is placed in a mold having the desired overall shape and configuration of the bladder. The mold has an opening at one location through which pressurized air is provided. The pressurized air induces the liquefied elastomeric material to conform to the shape of the inner surfaces of the mold. The elastomeric material then cools, thereby forming a bladder with the desired shape and configuration.

SUMMARY OF THE INVENTION

The present invention is an article of footwear incorporating a sole component that includes a bladder and a reinforcing structure. The bladder is formed of a barrier material, and the bladder encloses a pressurized fluid that exerts an outward force upon the barrier material. The reinforcing structure is at least partially recessed into the barrier material and bonded to the barrier material. At least a portion of the reinforcing structure may be placed in tension by the outward force upon the barrier material. The reinforcing structure may also restrain distension or outwardly-directed swelling of the bladder due to the outward force upon the barrier material, and the reinforcing structure may be formed of a material with a greater modulus of elasticity than the barrier material.

The bladder may include a first surface and an opposite second surface. The first surface may be joined to the second

surface by a plurality of interior bonds that are spaced inward from a sidewall of the bladder. In addition, the bladder may include at least one flexion indentation formed in the second surface, the indentation may extend, for example, from a lateral side of the bladder to a medial side of the bladder. As an alternative, the indentation may extend in a generally longitudinal direction. At least one of the interior bonds may join the first surface with the indentation.

The reinforcing structure may include a first portion, a second portion, and a plurality of connecting portions. The first portion may be positioned at an interface of the first surface and the sidewall, and the first portion may extend along a lateral side of the bladder, around a heel region of the bladder, and along a medial side of the bladder. The second portion may be spaced from the first portion and positioned at an interface of the second surface and the sidewall. In addition, the second portion may extend along the lateral side, around the heel region, and along a medial side of the bladder. The connecting portions may extend along the sidewall and between the first portion and the second portion, with the connecting portions being recessed into sidewall. The connecting portions may also be inclined with respect to the first portion and the second portion.

Another aspect of the present invention involves a method of manufacturing a sole component for an article of footwear. The method includes the steps of molding a fluid-filled bladder from a polymer material, recessing a reinforcing member into the bladder, and bonding the reinforcing member to the bladder. Accordingly, the reinforcing member may be placed within the mold prior to introducing the polymer material forming the bladder.

The advantages and features of novelty characterizing the present invention are pointed out with particularity in the appended claims. To gain an improved understanding of the advantages and features of novelty, however, reference may be made to the following descriptive matter and accompanying drawings that describe and illustrate various embodiments and concepts related to the invention.

DESCRIPTION OF THE DRAWINGS

The foregoing Summary of the Invention, as well as the following Detailed Description of the Invention, will be better understood when read in conjunction with the accompanying drawings.

FIG. 1 is a lateral side elevational view of an article of footwear having a first sole component in accordance with the present invention.

FIG. 2 is a first perspective view of the first sole component.

FIG. 3 is a second perspective view of the first sole component.

FIG. 4 is a third perspective view of the first sole component.

FIG. 5 is a top plan view of the first sole component.

FIG. 6 is a bottom plan view of the first sole component.

FIG. 7 is a first side elevational view of the first sole component.

FIG. 8 is a second side elevational view of the first sole component.

FIGS. 9A-9E are cross-sectional views of the first sole component, as defined by section lines 9A-9E in FIG. 5.

FIG. 9F is a cross-sectional view of the first sole component, as defined by section line 9F-9F in FIG. 7.

FIG. 9G is a cross-sectional view of the article of footwear, as defined by section line 9G-9G in FIG. 1.

FIG. 10 is a first exploded perspective view of the first sole component.

FIG. 11 is a second exploded perspective view of the first sole component.

FIG. 12A is a top plan view of an upper mold portion of a mold for forming the first sole component.

FIG. 12B is a side elevational view of the upper mold portion.

FIG. 13A is a top plan view of a lower mold portion of the mold.

FIG. 13B is a side elevational view of the lower mold portion.

FIGS. 14A-14E depict various manufacturing steps in forming the first sole component.

FIG. 15 is a perspective view of a second sole component in accordance with the present invention.

FIG. 16 is an exploded perspective view of the second sole component.

FIG. 17 is a perspective view of a third sole component in accordance with the present invention.

FIG. 18 is an exploded perspective view of the third sole component.

FIG. 19 is a perspective view of another embodiment of the third sole component.

FIG. 20 is a side elevational view of the footwear depicting yet another embodiment of the third sole component.

FIG. 21 is a top plan view of a fourth sole component.

FIG. 22 is a lateral side elevational view of an article of footwear having a fifth sole component in accordance with the present invention.

FIG. 23 is a perspective view of the fifth sole component.

FIG. 24 is a lateral side elevational view of an article of footwear having a sixth sole component in accordance with the present invention.

FIG. 25 is a perspective view of a seventh sole component in accordance with the present invention.

FIG. 26 is a first side elevational view of an eighth sole component in accordance with the present invention.

FIGS. 27A and 27B are cross-sectional views of the eighth sole component, as defined by section lines 27A and 27B in FIG. 26.

FIG. 28 is a cross-sectional view corresponding with FIG. 9E and depicting another embodiment of the first sole component.

FIGS. 29A and 29B are cross-sectional views corresponding with FIG. 9C and depicting yet another embodiment of the first sole component.

FIGS. 30A and 30B are side elevational views of a ninth sole component in accordance with the present invention.

FIGS. 31A and 31B are side elevational views of a tenth sole component in accordance with the present invention.

FIG. 32 is a cross-sectional view through a heel region of an eleventh sole component in accordance with the present invention.

FIG. 33 is a side elevational view of a twelfth sole component in accordance with the present invention.

FIG. 34 is a side elevational view of a thirteenth sole component in accordance with the present invention.

FIGS. 35A and 35B are cross-sectional views of the thirteenth sole component, as defined by section lines 35A and 35B in FIG. 34.

FIG. 36 is a side elevational view of the thirteenth sole component in combination with an outsole.

FIGS. 37A and 37B are cross-sectional views of the thirteenth sole component and outsole, as defined by section lines 37A and 37B in FIG. 36.

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FIG. 37C is a cross-sectional view corresponding with FIG. 37B and showing an alternate configuration.

FIG. 38 is a lateral side elevational view of an article of footwear having a fourteenth sole component in accordance with the present invention.

FIGS. 39A and 39B are side elevational views of the fourteenth sole component.

FIGS. 40A and 40B are schematic bottom plan views of outsoles.

DETAILED DESCRIPTION OF THE INVENTION

Introduction

The following discussion and accompanying figures disclose various embodiments of a sole component suitable for footwear applications. In addition, a method of manufacturing the sole component is disclosed. Concepts related to the sole component and manufacturing method are disclosed with reference to footwear having a configuration that is suitable for running. The sole component is not limited solely to footwear designed for running, and may be applied to a wide range of athletic footwear styles, including basketball shoes, cross-training shoes, walking shoes, tennis shoes, soccer shoes, and hiking boots, for example. The sole component may also be applied to footwear styles that are generally considered to be non-athletic, including dress shoes, loafers, sandals, and work boots. The concepts disclosed herein apply, therefore, to a wide variety of footwear styles.

An article of footwear 10, as depicted in FIG. 1, includes an upper 11 and a sole structure 12. Upper 11 may incorporate a plurality material elements (e.g., textiles, foam, and leather) that are stitched or adhesively bonded together to form an interior void for securely and comfortably receiving a foot. The material elements may be selected and located with respect to upper 11 in order to selectively impart properties of durability, air-permeability, wear-resistance, flexibility, and comfort, for example. In addition, upper 11 may include a lace that is utilized in a conventional manner to modify the dimensions of the interior void, thereby securing the foot within the interior void and facilitating entry and removal of the foot from the interior void. The lace may extend through apertures in upper 11, and a tongue portion of upper 11 may extend between the interior void and the lace. Accordingly, upper 11 itself may have a substantially conventional configuration within the scope of the present invention.

Sole structure 12 is secured to upper 11 and includes a midsole 13 and an outsole 14. A conventional midsole is primarily formed of a polymer foam material, such as polyurethane or ethylvinylacetate, as discussed in the Background of the Invention section. In contrast with the structure of a conventional midsole, midsole 13 incorporates a sole component 20, as depicted in FIGS. 2-11, that includes a fluid-filled bladder 30 and an external reinforcing structure 40. Sole component 20 provides ground reaction force attenuation as footwear 10 impacts the ground during running, walking, or other ambulatory activities. In addition, sole component 20 may impart stability or otherwise control foot motions, such as the degree of pronation. Outsole 14 is secured to a lower surface of midsole 13 and is formed of a durable, wear-resistant material suitable for engaging the ground. Sole structure 12 may also include an insole 18 with the configuration of a thin cushioning member. Insole 18 may be positioned within the interior void formed by upper 11 and located to contact a plantar surface of the foot, thereby enhancing the overall comfort of footwear 10.

The following discussion references various general regions of footwear 10, upper 11, and sole structure 12 based

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upon their relative locations. For reference purposes, footwear 10 may be divided into three general regions: a forefoot region 15, a midfoot region 16, and a heel region 17, as depicted in FIG. 1. Forefoot region 15 generally includes portions of footwear 10 corresponding with the toes and the joints connecting the metatarsals with the phalanges. Midfoot region 16 generally includes portions of footwear 10 corresponding with the arch area of the foot, and heel region 17 corresponds with rear portions of the foot, including the calcaneus bone. Regions 15-17 are not intended to demarcate precise areas of footwear 10. Rather, regions 15-17 are intended to represent general areas of footwear 10 to aid in the following discussion. In addition to footwear 10, regions 15-17 may also be applied to upper 11, sole structure 12, and individual elements thereof.

Sole Component Structure

Sole component 20 includes an upper surface 21 and an opposite lower surface 22. Upper surface 21 is secured to upper 11 in a conventional manner, such as adhesive bonding, and may be contoured to conform with the shape of the plantar surface of the foot. Accordingly, upper surface 21 may exhibit an elevation in heel region 15 that is greater than an elevation in forefoot region 15, with midfoot region 16 forming a transition between the elevations. Differences in the overall thickness of sole component 20 account for the elevation in heel region 15 that is greater than the elevation in forefoot region 15. In general, the thickness of sole component 20 may range, for example, from 0.15 inches in the forward-most portion of forefoot region 15 to approximately 0.70 inches at the interface of forefoot region 15 and midfoot region 16. Similarly, the thickness of sole component 20 may range, for example, from 0.70 inches to approximately 1.20 inches in heel region 17.

The overall shape of sole component 20, as depicted in the plan view of FIGS. 5 and 6, corresponds with the shape of a foot. Accordingly, the width of heel region 17 may be less than a width of forefoot region 15 to accommodate the varying width dimensions of the foot. Outsole 14 is also secured to lower surface 22 in a conventional manner, such as adhesive bonding. In addition to upper surface 21 and lower surface 22, sole component 20 includes a lateral side surface 23 and an opposite medial side surface 24. Both side surfaces 23 and 24 are exposed portions of midsole 13 and have a tapered configuration from heel region 17 to forefoot region 15 that facilitates the difference in elevation between heel region 17 and forefoot region 15.

The primary elements of bladder 30 are a upper barrier layer 31 and a lower barrier layer 32 that are substantially impermeable to a pressurized fluid contained by bladder 30. Upper barrier layer 31 and lower barrier layer 32 are bonded together around their respective peripheries to form a peripheral bond 33 and cooperatively form a sealed chamber, in which the pressurized fluid is located. The pressurized fluid contained by bladder 30 induces an outward force upon barrier layers 31 and 32 that tends to separate or otherwise press outward upon barrier layers 31 and 32, thereby distending barrier layers 31 and 32. In order to restrict the degree of outwardly-directed swelling (i.e., distension) of barrier layers 31 and 32 due to the outward force of the pressurized fluid, a plurality of interior bonds 34 are formed between barrier layers 31 and 32. Interior bonds 34 are spaced inward from side surfaces 23 and 24, and interior bonds 34 are distributed throughout sole component 20. In the absence of interior bonds 34, the outward force induced by the pressurized fluid would impart a rounded or otherwise bulging configuration to bladder 30, particularly in areas corresponding with upper

surface **21** and lower surface **22**. Interior bonds **34**, however, restrict the degree of the outwardly-directed swelling or distension of barrier layers **31** and **32** and retain the intended contours of upper surface **21** and lower surface **22**.

Interior bonds **34** may exhibit a variety of configurations within the scope of the present invention. In heel region **17**, the indentations formed by interior bonds **34** have a greater depth than in forefoot region **15** due to the increased overall thickness of sole component **20** in heel region **17**. In addition, the area of each interior bond **34** in heel region **17** is generally greater than the area of each interior bond **34** in forefoot region **15**. The position of interior bonds **34** with respect to upper surface **21** and lower surface **22** may also vary. For example, interior bonds **34** may be positioned so as to be closer to upper surface **21**, midway between surfaces **21** and **22**, or at a position that is closer to lower surface **22**.

During running or walking, sole component **20** generally flexes or otherwise bends to accommodate the natural flexing of the foot, particularly in forefoot region **15**. In order to facilitate the flexing of sole component **20**, a pair of flexion indentations **35** are formed in bladder **30**. Each flexion indentation **35** extends laterally across a lower portion of bladder **30**. That is, flexion indentations **35** extend between side surfaces **23** and **24**, and flexion indentations **35** are formed in lower surface **22**. The location of flexion indentations **35** is also selected based upon the average location of the joints between the metatarsals and the proximal phalanges of the foot. More particularly, flexion indentations **35** are spaced such that one flexion indentation **35** is located forward of the joints between the metatarsals and the proximal phalanges and the other flexion indentation **35** is located behind the joints between the metatarsals and the proximal phalanges. The specific locations of flexion indentations **35** may be selected, for example, to be three standard deviations away from the average position of the joints between the metatarsals and the proximal phalanges, as determined through statistical anatomical data. Depending upon the specific configuration and intended use of sole component **20**, however, the location of flexion indentations **35** may vary significantly from the positions discussed above.

Flexion indentations **35** extend laterally (i.e., between side surfaces **23** and **24**) across lower surface **22**. Although this configuration is suitable for footwear structured for running and a variety of other athletic activities, flexion indentations **35** may extend in a generally longitudinal direction (i.e., between forefoot region **15** and heel region **17**) in footwear structured for athletic activities such as basketball, tennis, or cross-training. Accordingly, flexion indentations **35** may extend in a variety of directions in order to provide a defined line of flexion in sole component **20**. The figures also depict flexion indentations **35** as extending entirely across bladder **30**. In some embodiments, however, flexion indentations **35** may extend only partially across a portion of bladder **30**.

Flexion indentations **35** define portions of sole component **20** that have a reduced thickness. Given that the degree of force necessary to bend an object is generally dependent upon the thickness of the object, the reduced thickness of sole component **20** in the areas of flexion indentations **35** facilitates flexing. In addition, portions of outsole **14** may extend into flexion indentations **35**, thereby forming a stiffer, less compressible areas of sole structure **12** that also facilitate flexing about flexion indentations **35**.

Flexion indentations **35** form an indentation in lower surface **22** that corresponds with the locations of various interior bonds **34**. Referring to FIG. 9D, a cross-section through one of flexion indentations **35** is depicted. With respect to this area, interior bonds **34** extend downward to bond upper bar-

rier layer **31** with the portion of lower barrier layer **32** that defines the flexion indentation **35**. Some prior art bladders incorporate bonds that form flexion points, and the flexion points may form relatively hard areas due to the lack of a fluid cushion in the area of the flexion points. That is, the flexion points generally form non-cushioning areas of the prior art bladders. In contrast with the prior art flexion points, flexion indentations **35** form a fluid-filled portion of bladder **30** in areas between the connection of interior bonds **34** to flexion indentations **35**. In other words, a space is formed between flexion indentations **35** and upper barrier layer **31** that includes the fluid such that flexion indentations **35** provide an advantage of simultaneously accommodating flexing and providing ground reaction force attenuation. As an alternative, no interior bonds **34** may be formed in areas that define flexion indentations **35**.

A variety of thermoplastic polymer materials may be utilized for bladder **30**, and particularly barrier layers **31** and **32**, including polyurethane, polyester, polyester polyurethane, and polyether polyurethane. Another suitable material for bladder **30** is a film formed from alternating layers of thermoplastic polyurethane and ethylene-vinyl alcohol copolymer, as disclosed in U.S. Pat. Nos. 5,713,141 and 5,952,065 to Mitchell et al, hereby incorporated by reference. A variation upon this material wherein the center layer is formed of ethylene-vinyl alcohol copolymer; the two layers adjacent to the center layer are formed of thermoplastic polyurethane; and the outer layers are formed of a regrind material of thermoplastic polyurethane and ethylene-vinyl alcohol copolymer may also be utilized. Bladder **30** may also be formed from a flexible microlayer membrane that includes alternating layers of a gas barrier material and an elastomeric material, as disclosed in U.S. Pat. Nos. 6,082,025 and 6,127,026 to Bonk et al., both hereby incorporated by reference. In addition, numerous thermoplastic urethanes may be utilized, such as PELLETHANE, a product of the Dow Chemical Company; ELASTOLLAN, a product of the BASF Corporation; and ESTANE, a product of the B.F. Goodrich Company, all of which are either ester or ether based. Still other thermoplastic urethanes based on polyesters, polyethers, polycaprolactone, and polycarbonate macrogels may be employed, and various nitrogen blocking materials may also be utilized. Additional suitable materials are disclosed in U.S. Pat. Nos. 4,183,156 and 4,219,945 to Rudy, hereby incorporated by reference. Further suitable materials include thermoplastic films containing a crystalline material, as disclosed in U.S. Pat. Nos. 4,936,029 and 5,042,176 to Rudy, hereby incorporated by reference, and polyurethane including a polyester polyol, as disclosed in U.S. Pat. Nos. 6,013,340; 6,203,868; and 6,321,465 to Bonk et al., also hereby incorporated by reference.

The fluid within bladder **30** may be any of the gasses disclosed in U.S. Pat. No. 4,340,626 to Rudy, hereby incorporated by reference, such as hexafluoroethane and sulfur hexafluoride, for example. The fluid may also include gasses such as pressurized octafluoropropane, nitrogen, or air. In addition to gasses, various gels or liquids may be sealed within bladder **30**. Accordingly, a variety of fluids are suitable for bladder **30**. With regard to pressure, a suitable fluid pressure is fifteen pounds per square inch, but may range from zero to thirty pounds per square inch. Accordingly, the fluid pressure within bladder **30** may be relatively high, or the fluid pressure may be at ambient pressure or at a pressure that is slightly elevated from ambient in some embodiments of the invention.

Reinforcing structure **40** forms a reinforcing cage that is bonded or otherwise secured to an exterior of bladder **30**. In general, reinforcing structure **40** generally extends around

portions of the periphery of bladder 30, and portions of reinforcing structure 40 extend along side surfaces 23 and 24 of sole component 20. Reinforcing structure 40 extends, therefore, between upper surface 21 and lower surface 22. In addition, the material forming reinforcing structure 40 exhibits a greater modulus of elasticity than the material forming bladder 30. Accordingly, the configuration and material properties of reinforcing structure 40 may impart reinforcement to sole component 20.

Interior bonds 34, as discussed above, are spaced inward from side surfaces 23 and 24 to restrict the degree of outwardly-directed swelling (i.e., distension) of barrier layers 31 and 32, particularly in areas corresponding with upper surface 21 and lower surface 22. Interior bonds 34 may not, however, significantly restrict the outwardly-directed swelling of side surfaces 23 and 24. One purpose of reinforcing structure 40 is, therefore, to restrict the degree of outwardly-directed swelling in side surfaces 23 and 24, thereby retaining the intended overall shape of sole component 20.

Reinforcing structure 40 includes an upper portion 41, a lower portion 42, and a plurality of connecting portions 43. Upper portion 41 exhibits a generally U-shaped configuration and is positioned at the interface of upper surface 21 and side surfaces 23 and 24. Accordingly, upper portion 41 extends along lateral side 23 from forefoot region 15 to heel region 17, extends around heel region 17, and also extends along medial side 24 from forefoot region 15 to heel region 17. Lower portion 42 also exhibits a generally U-shaped configuration and is positioned at the interface of lower surface 22 and side surfaces 23 and 24. Whereas upper portion 41 extends over portions of both upper surface 21 and side surfaces 23 and 24, lower portion 42 extends over side surfaces 23 and 24. That is, lower portion 42 covers areas of side surfaces 23 and 24 that are adjacent to lower surface 22, but lower portion 42 does not generally extend over lower surface 22. Lower portion 42 extends through heel region 17 and may extend into midfoot region 16. As depicted in the figures, however, lower portion 42 does not extend into forefoot region 15. Connecting portions 43 extend along side surfaces 23 and 24 and also extend between upper portion 41 and lower portion 42. Connecting portions 43 extend in a diagonal direction between upper portion 41 and lower portion 42. More particularly, connecting portions 43 exhibit a forwardly-inclined configuration, but may also be substantially vertical or rearwardly-inclined.

Upper portion 41, lower portion 42, and connecting portions 43 collectively form a plurality of apertures that expose portions of bladder 30. The apertures extend along side surfaces 23 and 24 in at least heel region 17, and the shape of the apertures generally depends upon the orientations of connecting portions 43 and the configurations of upper portion 41 and lower portion 42. The apertures formed through reinforcing structure 40 have a variety of shapes that include, for example, a parallelogram, oval, hexagon, triangle, circle, or various non-geometric shapes. The shape of the apertures may affect the compression characteristics of reinforcing structure 40 and may be selected, therefore, to provide particular properties to reinforcing structure 40.

Reinforcing structure 40 restricts the degree of outwardly-directed swelling in side surfaces 23 and 24, thereby retaining the intended overall shape of sole component 20. That is, the pressurized fluid within bladder 30 presses outward upon barrier layers 31 and 32, and reinforcing structure 40 restrains the distension in side surfaces 23 due to the fluid. Portions of reinforcing structure 40 are, therefore, placed in tension by the pressurized fluid. Although upper portion 41 and lower portion 42 may experience such tension, connecting portions 43, which extend along side surfaces 23 and 24, may gener-

ally experience greater degrees of tension. Accordingly, connecting portions 43 are placed in tension by the fluid pressure and operate to restrict the degree of outwardly-directed swelling or distension in side surfaces 23 and 24.

The specific configuration of reinforcing structure 40 discussed above is intended to provide an understanding of reinforcing structure 40 according to one embodiment of the invention, and as depicted in FIGS. 2-11. In further embodiments of the invention, however, the configuration of reinforcing structure 40 may be significantly modified. For example, upper portion 41 may be limited to heel region 17 and midfoot region 16, upper portion 41 may extend only over portions upper surface 21, or upper portion 41 may extend only over portions of side surface 23 and 24. Similarly, lower portion 42 may extend through each of regions 15-17, or lower portion 42 may extend over portions of lower surface 22. Connecting portions 43 may also exhibit a configuration that extends along side surfaces 23 and 24 in midfoot region 16 and forefoot region 15, and the numbers and dimensions of connecting portions 43 may vary significantly. Accordingly, reinforcing structure 40 may have a variety of configurations within the scope of the present invention.

Reinforcing structure 40 is recessed into bladder 30 such that an outward-facing surface of reinforcing structure 40 is generally flush with surfaces 21-24 of bladder 30. Referring to FIG. 9F, a cross-sectional view through a portion of sole component 20 is depicted. The outward-facing surface of connecting portion 43, as depicted in the cross-sectional view, is generally flush with lateral side surface 23. Accordingly, lateral side surface 23 forms a recess that receives connecting portion 43. That is, lateral side surface 23 curves into bladder 30 so as to form a depression in which connecting portion 43 is positioned. In this manner, the various outward-facing surfaces of reinforcing structure 40 are generally flush with surfaces 21-24 of bladder 30. Forming the various outward-facing surfaces of reinforcing structure 40 to be generally flush with surfaces 21-24 of bladder 30 has an advantage of providing a smooth exterior configuration to sole component 20. In some embodiments of the invention, however, the outward-facing surfaces of reinforcing structure 40 may be inset or recessed into bladder 30 or may protrude outward beyond bladder 30.

The various recesses that receive reinforcing structure 40 are depicted in the exploded view of FIG. 10. More particularly, bladder 30 defines a first recess 51, a second recess 52, and a plurality of third recesses 53. First recess 51 corresponds with the location of upper portion 41 and extends, therefore, around the perimeter of upper surface 21. Portions of first recess 51 also extend along side surfaces 23 and 24 at the interface of upper surface 21 and side surfaces 23 and 24. Second recess 52 corresponds with the location of lower portion 42 and is, therefore, positioned adjacent to peripheral bond 33 in heel region 17 and portions of midfoot region 16. In addition, the plurality of third recesses 51 extend between first recess 51 and second recess 52 to correspond with the locations of connecting portions 43.

An injection-molding process or compression-molding process, for example, may be utilized to form reinforcing structure 40 from a diverse range of materials. Suitable materials for reinforcing structure 40 include polyester, thermoset urethane, thermoplastic urethane, various nylon formulations, blends of these materials, or blends that include glass fibers. In addition, reinforcing structure 40 may be formed from a high flex modulus polyether block amide, such as PEBAX, which is manufactured by the Atofina Company. Polyether block amide provides a variety of characteristics that benefit the present invention, including high impact resis-

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tance at low temperatures, few property variations in the temperature range of minus 40 degrees Celsius to positive 80 degrees Celsius, resistance to degradation by a variety of chemicals, and low hysteresis during alternative flexure. Another suitable material for reinforcing structure **40** is a polybutylene terephthalate, such as HYTREL, which is manufactured by E.I. duPont de Nemours and Company. Composite materials may also be formed by incorporating glass fibers or carbon fibers into the polymer materials discussed above in order to enhance the strength of reinforcing structure **40**.

As discussed above, the material forming reinforcing structure **40** exhibits a greater modulus of elasticity than the material forming bladder **30**. Whereas the material forming bladder **30** is generally flexible, the material forming reinforcing structure **40** may exhibit semi-rigid or rigid properties. Comparisons between bladder **30** and reinforcing structure **40** may also relate to the melting point and recrystallization temperatures. As discussed in greater detail below, materials forming bladder **30** and reinforcing structure **40** are joined through a molding process. Although the melting point and recrystallization temperatures of bladder **30** and reinforcing structure **40** may vary significantly, a difference in melting points that is less than 35 degrees Celsius and a difference in recrystallization temperatures that is at least 5 degrees Celsius may be beneficial to the manufacturing process. In some embodiments, the ultimate tensile strength of the material forming bladder **30** may be less than the ultimate tensile strength of the material forming reinforcing structure **40**.

Although reinforcing structure **40** may be formed from a single material, two or more materials may be incorporated into reinforcing structure **40** in some embodiments of the invention. For example, upper portion **41** may be formed from a material that exhibits lesser stiffness than a material forming lower portion **42** and connecting portions **43**. This configuration provides a softer material adjacent to upper **11**, which may enhance the comfort of footwear **10** and promote bonding between sole structure **12** and upper **11**. Portions of reinforcing structure **40** corresponding with lateral side surface **23** may also be formed with lesser stiffness than the portions of reinforcing structure **40** corresponding with medial side surface **24**. In addition, some embodiments may vary the materials throughout reinforcing structure **40** in order to provide specific compression, stability, and flexibility properties to particular portions of reinforcing structure **40**.

Sole component **20**, as described above, provides ground reaction force attenuation as footwear **10** impacts the ground during running, walking, or other ambulatory activities. In addition, sole component **20** may impart stability or otherwise control foot motions, such as the degree of pronation. The degree of ground reaction force attenuation provided by sole component **20**, and the manner in which sole component **20** controls foot motions, are primarily determined by the configuration of both bladder **30** and reinforcing structure **40** and the properties of the materials forming bladder **30** and reinforcing structure **40**. Accordingly, variations in the configuration of both bladder **30** and reinforcing structure **40**, and the materials utilized therein, may be employed to tune or otherwise control the ground reaction force attenuation and motion control properties of sole structure **12**. The manner in which sole component **20** may be configured to control the ground reaction force attenuation and motion control properties of footwear **10** will be discussed in greater detail in the following material.

Lower surface **22** forms an upwardly-beveled area **25** in a rear-lateral portion of sole component **20** in order to permit

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the footwear to smoothly roll both forward and to the medial side following heel strike. As depicted in FIGS. **1**, **6**, and **7**, the vertical thicknesses of the portions of bladder **30** and reinforcing structure **40** forming lateral side surface **23** decrease in rear portions of heel region **17**. The rationale for the decreased thickness, which forms beveled area **25**, corresponds with the typical motion of the foot during running, which proceeds as follows: Initially, the heel strikes the ground, followed by the ball of the foot. As the heel leaves the ground, the foot rolls forward so that the toes make contact, and finally the entire foot leaves the ground to begin another cycle. During the time that the foot is in contact with the ground and rolling forward, it also rolls from the outside or lateral side to the inside or medial side, a process called pronation. While the foot is air-borne and preparing for another cycle, the opposite process, called supination, occurs.

An advantage of beveled area **25** is to permit footwear **10** to smoothly transition from the position at heel strike, wherein only the rear-lateral portion of sole structure **12** is in contact with the ground, to the position where a substantial portion of outsole **14** is in contact with the ground. That is, beveled area **25** permits footwear **10** to smoothly roll both forward and to the medial side following heel strike. As with bladder **30**, the thickness of reinforcing structure **40** is also reduced to form beveled area **25**. Furthermore, the positions of connecting portions **43** are selected such that a space is formed between two adjacent connecting portions **43** at the location of beveled area **25**. The space between adjacent connecting portions **43** further facilitates a smooth transition from the position at heel strike by providing greater compressibility to sole component **20** at the position of beveled area **25**.

The compressibility of specific areas of sole component **20** affects the ground reaction force attenuation and motion control properties of sole component **20**. In general, forming sole component **20** such that peripheral areas (i.e., the areas adjacent to side surfaces **23** and **24**) are less compressible than interior areas enhances the stability of sole component **20**. One manner in which peripheral compressibility is decreased in sole component **20** is through reinforcing structure **40**. The position of reinforcing structure **40** around the periphery of sole component **20**, coupled with the semi-rigid, less flexible properties of the material forming reinforcing structure **40**, operates to decrease the compressibility of the periphery, thereby enhancing stability.

The distribution and configurations of the various interior bonds **34** also affects the compressibility and flexibility of sole component **20**. In general, interior bonds **34** are spaced inward from side surfaces **23** and **24**, and interior bonds **34** are spaced from each other. Interior bonds **34** form indentations in bladder **30**. Whereas surfaces **21** and **22** are generally horizontal, the material forming barrier layers **31** and **32** extend in a generally vertical direction to form the indentations of interior bonds **34**. During compression of sole component **20**, the vertically-extending material forming interior bonds **34** also compresses, bends, or otherwise deforms, thereby decreasing the compressibility of sole component **20** in areas immediately adjacent to interior bonds **34**. That is, the presence of an interior bond **34** decreases the compressibility of sole component **20** in the area immediately adjacent to the interior bond **34**.

Pronation, which is the rolling of the foot from the outside or lateral side to the inside or medial side, is a natural motion of the foot during running. Some individuals, however, pronate to a degree that is generally considered to be undesirable and sole component **20** may be configured, therefore, to limit the degree of pronation. As discussed above, interior bonds **34** decrease the compressibility of sole component **20**

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in specific areas. By positioning a greater number, for example, of interior bonds **34** on the medial side of sole component **20**, the compressibility of the medial side may be decreased. As the foot rolls from the lateral side to the medial side, the increased compressibility may operate to limit the degree of pronation in the foot. Accordingly, the distribution of interior bonds **34** may be selected to control foot motions, such as pronation.

The ground reaction force attenuation and motion control properties of sole component **20** may also be affected by the configuration of reinforcing structure **40**. The dimensions of upper portion **41**, lower portion **42**, and connecting portions **43** may be selected to provide specific degrees of flexibility and compressibility to portions of reinforcing structure **40**. For example, the compressibility of peripheral areas of sole component **20** may be selected through modifications in the overall thickness of upper portion **41**. Similarly, the compressibility of heel region **17** may be selected through modifications in the dimensions or number of connecting portions **43**. The thickness of reinforcing structure **40** may also be tapered between upper portion **41** and lower portion **42** in order to control the compressibility of reinforcing structure **40** or limit the degree to which reinforcing structure creases or buckles during compression. In addition, a central area of connecting portions **43** may be thicker than upper or lower portions in order to impart a specific compressibility, for example. In some embodiments of the invention, reinforcing structure **40** may be formed from two or more materials. As discussed above, structuring sole component **20** to exhibit lesser medial compressibility may reduce the degree of pronation in the foot. Accordingly, the material selected for a lateral side of reinforcing structure **40** may have a lesser modulus of elasticity than the material selected for a medial side of reinforcing structure **40**, thereby decreasing the compressibility of the medial side.

Manufacturing Process

One suitable manufacturing process for sole component **20** utilizes a mold **100**, as depicted in FIGS. **12A-13B**. Mold **100** includes an upper mold portion **110** and a corresponding lower mold portion **120**. When joined together, mold portions **110** and **120** form a cavity having dimensions substantially equal to the exterior dimensions of sole component **20**. Mold **100** may be utilized for thermoforming bladder **30** and simultaneously bonding or otherwise securing reinforcing structure **40** to the exterior of bladder **30**. In general, reinforcing structure **40** is placed within upper mold portion **110** and two thermoplastic polymer sheets are placed between mold portions **110** and **120**. The thermoplastic sheets are then drawn into the contours of mold **100** such that at least one of the thermoplastic sheets contacts and is bonded to reinforcing structure **40**. In addition, mold portions **110** and **120** compress the thermoplastic sheets together to form peripheral bond **33**. Once the thermoplastic sheets have conformed to the shape of bladder **30**, reinforcing structure **40** is bonded to the thermoplastic sheets, peripheral bond **33** is formed, and bladder **30** may be pressurized with a fluid and sealed, thereby forming sole component **20**.

Upper mold portion **110** is depicted individually in FIGS. **12A** and **12B** and includes a cavity **111** that forms the portions of sole component **20** corresponding with upper surface **21** and side surfaces **23** and **24**. A ridge **112** extends around cavity **111** and is partially responsible for forming peripheral bond **33**. In addition, a plurality of protrusions **113** extend from a surface of cavity **111** and are partially responsible for forming interior bonds **34**. Accordingly, the area of upper mold portion **110** located within the area bounded by ridge

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112 forms upper surface **21** and side surfaces **23** and **24**. An extension of ridge **112** extends outward from cavity **111** and forms an L-shaped channel **114**. As discussed in greater detail below, channel **114** is utilized to form a conduit through which a fluid may be injected into sole component **20**. Another feature of upper mold portion **110** is a plurality of slot vents **115** distributed throughout cavity **111**. Vents **115** provide outlets for air as a thermoplastic sheet of polymer material is drawn into the contours of upper mold portion **110** during the formation of sole component **20**.

Lower mold portion **120** is depicted individually in FIGS. **13A** and **13B** and includes a surface **121** that forms the portion of sole component **20** corresponding with lower surface **22**. A ridge **122** extends around surface **121** and, in combination with ridge **112**, is responsible for forming peripheral bond **33**. In addition, a plurality of protrusions **123** extend from surface **121** and join with protrusions **113** to form interior bonds **34**. Accordingly, the area of lower mold portion **120** located within the area bounded by ridge **122** forms lower surface **22**. An extension of ridge **122** extends outward from surface **121** and forms an L-shaped channel **124**. Channel **124** joins with channel **114** to form the conduit through which the fluid may be injected into sole component **20**. Another feature of lower mold portion **120** is a plurality of slot vents **125** distributed throughout surface **121**. Vents **125** provide outlets for air as a thermoplastic sheet of polymer material is drawn into the contours of lower mold portion **120** during the formation of sole component **20**.

The manner in which mold **100** is utilized to form sole component **20** from reinforcing structure **40** and barrier layers **31** and **32** will now be discussed. An injection-molding process, for example, may be utilized to form reinforcing structure **40** from the materials discussed above. Reinforcing structure **40** is then cleansed with a detergent or alcohol, for example, in order to remove surface impurities, such as a mold release agent or fingerprints. The surface of reinforcing structure **40** may also be plasma treated to enhance bonding with bladder **30**.

Following formation and cleansing, reinforcing structure **40** is placed between mold portions **110** and **120** and then positioned within upper mold portion **110**, as depicted in FIGS. **14A** and **14B**, respectively. As discussed in the above material, upper mold portion **110** forms the portions of sole component **20** corresponding with upper surface **21** and side surfaces **23** and **24**. In the embodiment of sole component **20** discussed above, reinforcing structure **40** is generally bonded to upper surface **21** and side surfaces **23** and **24**. Accordingly, positioning reinforcing structure **40** within upper mold portion **110**, as depicted in FIG. **14B**, properly positions reinforcing structure **40** with respect to mold **100** for the process of forming sole component **20**. A variety of techniques may be utilized to secure reinforcing structure **40** within upper mold portion **110**, including a vacuum system, various seals, or non-permanent adhesive elements, for example. In addition, reinforcing structure **40** may include various tabs that define apertures, and upper mold portion **110** may include protrusion that engage the apertures to secure reinforcing structure **40** within upper mold portion **110**.

A plurality of conduits may extend through mold **100** in order to channel a heated liquid, such as water, through mold **100**. The heated liquid raises the overall temperature of mold **100** to approximately 180 degrees Fahrenheit. As noted above, reinforcing structure **40** is positioned within mold **100**, and reinforcing structure **40** conducts the heat from mold **100**, thereby raising the temperature of reinforcing structure **40** to approximately 180 degrees Fahrenheit. In some embodi-

ments of the invention, reinforcing structure **40** may be heated prior to placement within mold **100** in order to decrease manufacturing times.

Following placement of reinforcing structure **40** within upper mold portion **110**, a pair of thermoplastic polymer sheets that form barrier layers **31** and **32** are heated and then positioned between mold portions **110** and **120**, as depicted in FIG. **14C**. The temperature to which barrier layers **31** and **32** are heated depends upon the specific material used. As noted above, barrier layers **31** and **32** may be formed from a variety of materials, including alternating layers of thermoplastic polyurethane and ethylene-vinyl alcohol copolymer, which has a melting temperature between 350 and 360 degrees Fahrenheit. The temperature to which the surfaces of barrier layers **31** and **32** may be heated is between 400 and 450 degrees Fahrenheit, which generally melts the surface of barrier layers **31** and **32** without melting the interior.

The thickness of upper barrier layer **31** prior to molding may be greater than the thickness of lower barrier layer **32**. Although barrier layers **31** and **32** may exhibit different thicknesses prior to molding, each of barrier layers **31** and **32** may have a substantially uniform thickness prior to molding. A suitable thickness range for upper barrier layer **31** prior to molding is 0.045 to 0.090 inches, with one preferred thickness being 0.075 inches, and a suitable thickness range for lower barrier layer **32** prior to molding is 0.045 to 0.065 inches, with one preferred thickness being 0.055 inches. Whereas lower barrier layer **32** only forms lower surface **22**, upper barrier layer **31** forms both upper surface **21** and side surfaces **23** and **24**. The rationale for the difference in thickness is that upper barrier layer **31** may stretch to a greater degree in order to form both upper surface **21** and side surfaces **23** and **24**. Accordingly, differences between the original, pre-stretched thicknesses of barrier layers **31** and **32** compensate for thinning in upper barrier layer **31** that may occur when upper barrier layer **31** is stretched or otherwise distorted during the formation of upper surface **21** and side surfaces **23** and **24**.

Once barrier layers **31** and **32** are positioned, mold portions **110** and **120** are then located such that ridge **112** aligns with ridge **122** and the various protrusions **113** are aligned with protrusions **123**. In this position, the areas of mold portions **110** and **120** that form corresponding portions of sole component **20** are positioned on opposite sides of barrier layers **31** and **32** and are also aligned. Mold portions **110** and **120** then translate toward each other such that mold **100** contacts and compresses barrier layers **31** and **32**, as depicted in FIG. **14D**.

As mold **100** contacts and compresses portions of barrier layers **31** and **32**, a fluid, such as air, having a positive pressure in comparison with ambient air may be injected between barrier layers **31** and **32** to induce barrier layers **31** and **32** to respectively contact and conform to the contours of mold portions **110** and **120**. A variety of methods may be employed to pressurize the area between barrier layers **31** and **32**. For example, the fluid may be directed through the conduit formed by channels **114** and **124**. That is, a needle may be placed between barrier layers **31** and **32** and between channels **114** and **124** to deliver a fluid that travels down the conduit and into the area forming sole component **20**. Air may also be removed from the area between barrier layers **31** and **32** and mold portions **110** and **120** through vents **115** and **125**, thereby drawing barrier layers **31** and **32** onto the surfaces of mold portions **110** and **120**. That is, at least a partial vacuum may be formed between the barrier layers **31** and **32** and the surfaces of mold portions **110** and **120**. In addition, drawing barrier layers **31** and **32** onto the surfaces of mold portions **110** and **120** also draws barrier layers **31** and **32** into contact

with reinforcing structure **40**. Accordingly, barrier layers **31** and **32** contact and are bonded to reinforcing structure **40** during this portion of the manufacturing process.

As the area between barrier layers **31** and **32** is pressurized and air is removed from the area between barrier layers **31** and **32** and from between mold portions **110** and **120**, barrier layers **31** and **32** conform to the shape of mold **100** and are bonded together. More specifically, barrier layers **31** and **32** stretch, bend, or otherwise conform to extend along the surfaces of cavity **111** and surface **121** and form the general shape of bladder **30**. Ridge **112** and ridge **122** also compress a linear area of barrier layers **31** and **32** to form peripheral bond **33**. In addition, barrier layers **31** and **32** conform to the shapes of protrusions **113** and **123** and are bonded together by being compressed between protrusions **113** and **123**, thereby forming interior bonds **34**.

Although barrier layers **31** and **32** conform to extend along the surfaces of cavity **111** and surface **121**, upper barrier layer **31** generally does not contact the portions of cavity **111** that are covered by reinforcing structure **40**. Rather, upper barrier layer **31** contacts and is compressed against the inward-facing surface of reinforcing structure **40**, thereby bonding upper barrier layer **31** to reinforcing structure **40**. Referring to FIG. **9F**, the outward-facing surface of connecting portion **43** is generally flush with lateral side surface **23**, and lateral side surface **23** forms a recess that receives connecting portion **43**. That is, lateral side surface **23** curves into bladder **20** so as to form a depression in which connecting portion **43** is positioned. This configuration results from the manner in which reinforcing structure **40** is placed within upper mold portion **110** and upper barrier layer **31** is compressed against the inward-facing surface of reinforcing structure **40** and bonded to reinforcing structure **40**.

The various outward-facing surfaces of reinforcing structure **40** are generally flush with surfaces **21-24** of bladder **30**. As air pressurizes the area between barrier layers **31** and **32** and air is drawn out of mold **100** through vents **115** and **125**, both upper barrier layer **31** and reinforcing structure **40** are compressed against the surface of cavity **111**. Upper barrier layer **31** contacts the inward-facing surface of reinforcing structure **40**, conforms to the shape of reinforcing structure **40**, extends around reinforcing structure **40**, and contacts the surface of cavity **111**. In this manner, the surfaces of reinforcing structure **40** are formed to be generally flush with surfaces **21-24** of bladder **30**.

As barrier layers **31** and **32** conform to the shape of mold **100** and are bonded together, upper barrier layer **31** bends at the location of upper portion **41** to form side surfaces **23** and **24**. Accordingly, upper barrier layer **31** extends in a generally horizontal direction to form upper surface **21**, and upper barrier layer **31** bends at the location of upper portion **41** to extend in a generally vertical direction and form side surfaces **23** and **24**. Accordingly, upper barrier layer **31** bends during the process of molding bladder **30** in order to form upper surface **21** and side surfaces **23** and **24**.

The edges of reinforcing structure **40** exhibit a beveled configuration, as depicted in FIG. **9F**, in order to facilitate the flush nature of the interface between reinforcing structure **40** and bladder **30**. In general, if reinforcing structure **40** were formed to have a rectangular cross-section without beveling, for example, upper barrier layer **31** may be required to stretch to a greater degree, thereby causing undue thinning of upper barrier layer **31** in areas adjacent to reinforcing structure **40**. In addition, a lack of beveling may also cause a gap or space to form between upper barrier layer **31** and reinforcing structure **40**. Accordingly, reinforcing structure **40** is formed to exhibit beveled edges.

During formation of the bond between upper barrier layer 31 and reinforcing structure 40, air may become trapped between upper barrier layer 31 and reinforcing structure 40, thereby reducing the effectiveness of the bond. In order to facilitate the removal of air from between upper barrier layer 31 and reinforcing structure 40, a plurality of vent apertures 44 may be formed through selected locations of reinforcing structure 40, and may be formed through the area of upper portion 41 that corresponds with upper surface 21 in order to limit the visibility of vent apertures 44. Vent apertures provide outlets for air and may correspond in position with the various vents 115 in upper mold portion 110.

Once sole component 20 is formed within mold 100, mold portions 110 and 120 separate such that reinforcing structure 40 and barrier layers 31 and 32 may be removed from mold 100, as depicted in FIG. 14E. The polymer materials forming reinforcing structure 40 and barrier layers 31 and 32 are then permitted to cool, and a pressurized fluid may be injected through the conduit formed by channels 114 and 124. The conduit is then sealed to enclose the fluid within bladder 30. In addition, excess portions of barrier layers 31 and 32 may be trimmed or otherwise removed from sole component 20. The excess portions may then be recycled or reutilized to form additional thermoplastic sheets.

Connecting portions 43 are placed in tension by the pressurized fluid and operate to restrict the degree of outwardly-directed swelling (i.e., distension) in side surfaces 23 and 24. Prior to pressurization, reinforcing structure 40 and bladder 30 are generally in a non-tensioned state. The pressurized fluid, however, exerts an outward force upon bladder 30, thereby placing barrier layers 31 and 32 in tension. In the absence of reinforcing structure 40, the degree of outwardly-directed swelling of barrier layers 31 and 32 may induce a rounded or otherwise bulging configuration in side surfaces 23 and 24. Reinforcing member 40, and particularly connecting portions 43, restrain the outwardly-directed swelling due to the outward force of the pressurized fluid. Accordingly, tension is induced in connecting portions 43 through the pressurization of bladder 30.

The distribution and configurations of the various interior bonds 34, as discussed above, has an effect upon the compressibility of sole component 20. Modifications relating to the distribution and configurations of interior bonds 34, which are determined by the positions of protrusions 113 and 123 may be utilized to control various foot motions, such as pronation. Accordingly, foot motions may be controlled through modifications of mold portions 110 and 120. Footwear 10 may also be configured for use during different activities, such as running, basketball, and football, through modifications in the overall thickness of sole component 20, the distribution and configurations of the various interior bonds 34, and the configuration of reinforcing structure 40. Whereas a greater overall thickness of sole component 20 is suitable for running activities in order to provide greater ground reaction force attenuation, for example, a lesser overall thickness may be more appropriate for basketball and football in order to enhance stability. Controlling pronation may also be an issue with running activities, and protrusions 113 and 123 may be distributed and configured to control pronation when footwear 10 is intended for running. In contrast, the degree to which pronation is controlled through the distribution and configuration of protrusion 113 and 123 may be lessened when footwear 10 is intended for basketball or football. Accordingly, variations in the dimensions and configuration of sole component 20 may be utilized to tailor footwear 10 to specific athletic activities.

Interior bonds 34 may also be configured to affect other properties of sole component 20, such as stability. In some embodiments of the invention, selected interior bonds 34 may have an elongated configuration. Referring to the figures, an elongated interior bond 34 is positioned at the interface of midfoot region 16 and heel region 17 and extends in a medial-lateral direction. Another elongated interior bond 34 is positioned in heel region 17. Additional elongated interior bonds 34 are positioned in forefoot region 15 and may be oriented longitudinally or in the medial-lateral direction. In forward portions of forefoot region 15, for example, the elongate interior bonds 34 extend longitudinally. In comparison with round, triangular, or otherwise non-elongated interior bonds 34, the elongated interior bond 34 may exhibit increased resistance to shear forces, thereby enhancing the medial to lateral stability of sole component 20. Accordingly, the formation of elongated interior bonds 34 may be one manner of enhancing the overall stability of footwear 10.

The degree of elongation in the various interior bonds 34 also has an effect upon the compressibility of sole component 20 in the area of interior bonds 34. In general, circular interior bonds 34 exhibit greater compressibility than elongate interior bonds 34. With respect to forefoot region 15, many of the interior bonds 34 positioned between flexion indentations 35 exhibit a circular configuration in order to enhance the compressibility of this area. In forward portions of forefoot region 15, however, many of the interior bonds 34 exhibit an elongate configuration that decreases the compressibility of this area.

Various characteristics relating to the configuration of interior bonds 34 affects the overall configuration of sole component 20. In general, the spacing of interior bonds 34 in the medial to lateral direction is approximately 0.86 inches, but may be in a range of 0.5 to 0.6 inches in forward portions of forefoot region 15. The spacing of interior bonds 34 in the longitudinal direction is approximately 0.98 inches through heel region 17 and portions of midfoot region 16, but may be in a range of 0.4 to 0.9 inches in forefoot region 17. The radius formed in the transitions between surfaces 21 and 22 and the material extending inward to form interior bonds 34 has an effect upon the compressibility of interior bonds 34 and is generally selected to be in a range of 0.125 and 0.150 inches. In forward portions of forefoot region 15, however, the radius may be 0.1 inches.

Following the formation of sole component 20, upper 11 may be secured to upper surface 21 and outsole 14 may be secured to lower surface 22, thereby substantially completing the manufacture of footwear 10. The surface characteristics of sole component 20 may be adjusted to promote bonding between sole component 20 and other components of footwear 10. In general, the strength of an adhesive bond between lower surface 22 and outsole 14, for example, may be strengthened by forming lower surface 22 to have a relatively rough texture. Whereas an adhesive may not effectively adhere to an entirely smooth surface, the texture of a rough surface provides enhanced adhesive bonding. Although imparting a relatively rough texture to surfaces 21 and 22 may enhance bonding, a detriment to the relatively rough texture is decreased visibility through the polymer material forming bladder 30. Accordingly, a relatively smooth texture may be imparted to side surfaces 23 and 24 to enhance the visibility of those portions of sole component 20 that are visible when incorporated into footwear 10. The surface characteristics of sole component 20 are generally determined by the surface characteristics of mold 100. The portions of cavity 111 and surface 121 that form upper surface 21 and lower surface 22 may, therefore, be less smooth than portions of cavity 111 that

form side surfaces **23** and **24**. Texturing surfaces of sole component **20** may also enhance bonding between bladder **30** and reinforcing structure **40**. In some embodiments of the invention, the inward-facing surface of reinforcing structure **40** and the portions of upper barrier layer **31** that contact reinforcing structure **40** may be textured prior to bonding.

The process of bonding outsole **14** to lower surface **22** may be performed following the formation of sole component **20**, as discussed above. Alternately, one or more traction elements may be located within mold **100** in order to form a bond between the traction elements and lower surface **22** during the thermoforming process. That is, the traction elements may be bonded to bladder **30** through a process that is similar to the process of bonding reinforcing structure **40** to bladder **30**. The traction elements may be one or more elements of rubber material, for example, that are similar in configuration to a conventional outsole. The traction elements may also be additional elements of thermoplastic material that reinforce those areas of sole component **20** that contact the ground. Accordingly, the traction elements may have a variety of configurations within the scope of the present invention.

Upper portion **41** of reinforcing structure **40** extends along both the medial and lateral sides of sole component **40** and provides a defined lasting line for securing upper **11** to sole component **20**, as depicted in FIG. **9G**. One issue with some sole structures is that the precise extent to which the upper should be secured to the sole structure is not evident from the configuration of the sole structure. Referring to the cross-sections of FIGS. **9A-9E** and **9G**, reinforcing structure **40** forms a ridge **45** on both the medial and lateral sides of sole component **20**. Ridge **45** is an identifiable line that defines a lasting surface, thereby defining the portions of sole component **20** to which upper **11** should be secured. More particularly, upper **11** should be secured to the lasting surface, which is the portions of upper surface **21** that are positioned inward of ridge **45**. Accordingly, an adhesive, for example, may be placed between the portions of ridge **45** that are located on the medial and lateral sides in order to properly secure upper **11** to the lasting surface of sole component **20**.

The manner in which mold **100** is structured affects the resulting properties of sole component **20**. For example, the configurations of mold portions **110** and **120** have an effect upon the degree of stretch that may occur in barrier layers **31** and **32**. As discussed above, the thicknesses of barrier layers **31** and **32** may be selected to account for stretching during the molding process. In addition, however, mold portions **110** and **120** may be configured with draft angles that limit the degree of stretching in barrier layers **31** and **32**, thereby controlling the resulting thickness of barrier layers **31** and **32**. For example, the draft angles of the various protrusions **113** and **123** may range from 5 to 8 degrees and may extend upward to 13 degrees in heel region **17**.

The configurations of mold portions **110** and **120** also affect the placement of peripheral bond **33**. One advantage of placing peripheral bond **33** at the interface of lower surface **22** and side surfaces **23** and **24** is that unobstructed visibility is retained through side surfaces **23** and **24**. This configuration requires that upper barrier layer **31** stretch to a greater degree than lower barrier layer **32** in order to also form side surfaces **23** and **24**. In further embodiments of the invention, however, peripheral bond **33** may be positioned at a midpoint of side surface **23** and **24**, or peripheral bond **33** may be positioned at the interface of upper surface **21** and side surfaces **23** and **24**. Accordingly, the elevation of peripheral bond **33** may be selected to limit or otherwise control the degree of stretch in barrier layers **31** and **32**.

The relative elevations of interior bonds **34** also affect the degree of stretching that occurs in barrier layers **31** and **32**. If, for example, interior bonds **34** are located closer to lower surface **22** than upper surface **21**, then upper barrier layer **31** must stretch downward to form the indentations associated with interior bonds **34**. Similarly, locating interior bonds **34** closer to upper surface **21** causes lower barrier layer **32** to stretch upward to form the indentations associated with interior bonds **34**. When determining the configuration of mold **100**, the degree of stretch in barrier layers **31** and **32** may be calculated, and the relative heights of protrusions **113** and **123** may be selected to either increase or decrease the degree of stretch that occurs in areas of barrier layers **31** and **32**. Accordingly, the various interior bonds may each be formed at different elevations in order to control stretch in barrier layers **31** and **32**.

The relative heights of the various interior bonds **34** also affects the compressibility of sole component **20**. In general, the thicknesses of barrier layers **31** and **32** is proportional to the stiffness of barrier layers **31** and **32**. By forming interior bonds **34** adjacent to lower surface **22**, upper barrier layer **31** is drawn downward and stretched. The stretching lessens the thickness of upper barrier layer **31** and decreases the stiffness of upper barrier layer **31**, thereby increasing compressibility. By forming interior bonds **34** adjacent to upper surface **21**, however, upper barrier layer **31** is stretched to a lesser degree, thereby increasing the thickness of upper barrier layer **31** and decreasing compressibility.

As barrier layers **31** and **32** stretch during the thermoforming process, the thickness of barrier layers **31** and **32** decreases. The desired resulting thickness of barrier layers **31** and **32** generally depends upon the specific use and configuration of footwear **10**. Selecting the position of peripheral bond **33**, the locations of interior bonds **34**, and the initial thicknesses of barrier layers **31** and **32** provides control over the degree of stretch in barrier layers **31** and **32**. Accordingly, the position of peripheral bond **33**, the locations of interior bonds **34**, and the initial thicknesses of barrier layers **31** and **32** may be selected in order to optimize the overall thickness of bladder **30** in each area of sole component **20**.

Controlling the degree of stretch in barrier layers **31** and **32** may also be utilized to provide reinforcement to portions of bladder **30**. In general, areas of bladder **30** that have a greater thickness will be more durable than areas with a lesser thickness. The differences in the modulus of elasticity between the material forming bladder **30** and the material forming reinforcing structure **40** may cause wear at the interfaces between bladder **30** and reinforcing structure **40**. Accordingly, the degree of stretch in barrier layers **31** and **32** may be controlled to increase the thickness of bladder **30** in areas adjacent to reinforcing structure **40**. As discussed above, the degree of stretch in barrier layers **31** and **32** may be controlled through a variety of mechanisms, including the configuration of mold **100**, the relative thicknesses of barrier layers **31** and **32**, and the positions for forming interior bonds **34**, for example.

The degree of outwardly-directed swelling (i.e., distension) of barrier layers **31** and **32** due to the outward force of the pressurized fluid is restricted by interior bonds **34**. Despite the presence of interior bonds **34**, the portions of barrier layers **31** and **32** forming upper surface **21** and lower surface **22** may bow outward upon pressurization with the fluid sealed within bladder **30**. The outward bowing effectively bends areas of barrier layers **31** and **32** and may induce additional stresses in the thermoplastic polymer material forming bladder **30**. One manner of reducing the additional stresses in the thermoplastic polymer material forming bladder **30** is to mold

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or otherwise form barrier layers **31** and **32** to include curved surfaces corresponding with the distension that would occur as a result of pressurization.

Although thermoforming is a suitable manner of forming sole component **20**, a blow-molding process may also be utilized. In general, a suitable blow-molding process involves positioning reinforcing structure **40** within at least one of two mold portions and then positioning a parison between the mold portions, such as mold portions **110** and **120**. The parison is a generally hollow and tubular structure of molten polymer material. In forming the parison, the molten polymer material is extruded from a die. The wall thickness of the parison may be substantially constant, or may vary around the perimeter of the parison. Accordingly, a cross-sectional view of the parison may exhibit areas of differing wall thickness. Suitable materials for the parison include the materials discussed above with respect to bladder **30**. Following placement of the parison between the mold portions, the mold portions close upon the parison and pressurized air within the parison induces the liquefied elastomeric material to contact the surfaces of the mold. In addition, closing of the mold portions and the introduction of pressurized air induces the liquefied elastomeric material to contact the surfaces of reinforcing structure **40**. Air may also be evacuated from the area between the parison and the mold to further facilitate molding and bonding. Accordingly, sole component **20** may also be formed through a blow molding process wherein reinforcing structure **40** is placed within the mold prior to the introduction of the molten polymer material.

A variety of other manufacturing techniques may also be utilized to form sole component **20**, in addition to thermoforming and blow-molding. For example, bladder **30** may be formed separate from reinforcing structure **40**, and both components may be subsequently bonded together. A dual-injection technique may also be utilized to simultaneously form bladder **30** and reinforcing structure **40** from separate materials. In some embodiments, a first element corresponding with upper surface **21** and side surfaces **23** and **24** may be formed, a second element corresponding with lower surface **22** may be joined thereto, and a third element corresponding with reinforcing structure **40** may then be secured to the exterior. Accordingly, structures having the general shape and features of sole component **20** may be formed from a variety of processes.

Additional Sole Component Configurations

The specific configuration of sole component **20** disclosed above is intended to provide an example of a sole component within the scope of the present invention. Various alternate configurations, however, may also be utilized. Referring to FIGS. **15** and **16**, sole component **20** is depicted as having a plurality of bridges **46** that extend laterally across upper surface **21**. More particularly, four bridges **46** extend between medial and lateral sides of upper portion **41** and enhance the stability of sole component **20**. As depicted in the figures, bridges **46** are relatively narrow structures that are formed of unitary (i.e., one piece) construction with reinforcing structure **40** and are, therefore, secured to bladder **30**. As with other portions of reinforcing structure **40**, bridges **46** may be recessed within indentations in bladder **30** and may be bonded to bladder **30** during the thermoforming process. Although bridges **46** are depicted as being relatively narrow, the width of bridges **46** may be increased significantly depending upon the desired properties of sole component **20**, and bridges **46** may form a plate that extends over heel region **17**. Furthermore, bridges **46** may extend over lower surface **22** or both of surfaces **21** and **22**, and bridges **46** may extend

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through midfoot region **16** or heel region **17**. Accordingly, the specific configuration of bridges **46** may vary significantly within the scope of the present invention.

In addition to bridges **46**, sole component **20** may also include a plurality of extensions **47**, as depicted in FIGS. **17** and **18**. Extensions **47** are portions of reinforcing structure **40** that extend upward from sole component **20**. Extensions **47** may be secured to an exterior of upper **11** or may extend between the material elements forming upper **11** in order to further secure sole component **20** to upper **11**. One purpose of extensions **47** may be to extend around the foot in heel region **17**, for example, to provide additional support for the foot. Accordingly, extensions **47** may serve the purpose of a conventional heel counter or other stabilizing structure. Although extensions **47** may exhibit the elongated structure depicted in the figures, a similarly-located cup-like structure **48** that is analogous to structure of the conventional heel counter may be formed as a part of reinforcing structure **40**, as depicted in FIG. **19**. In yet another embodiment, as depicted in FIG. **20**, extensions **47** may be replaced by a plurality of lacing members **49** that are positioned to extend over the instep portion of upper **11** and form apertures for receiving the lace. Lacing members **49** may be utilized, therefore, as part of the lacing system that modifies the dimensions of the interior void, thereby securing the foot within the interior void and facilitating entry and removal of the foot from the interior void.

Bladder **30**, as disclosed in the above material, forms a single, sealed chamber for enclosing the pressurized fluid. Referring to FIG. **21**, bladder **30** is depicted as having a first chamber **36** and a second chamber **37** that are separated by a bond **38**. First chamber **36** extends through each of regions **15-17**, whereas second chamber **37** is limited to heel region **17**. The pressure of the fluid within second chamber **37** may be less than the pressure of the fluid within first chamber **36** such that different areas of bladder **30** exhibit differing ground reaction force attenuation and compressibility properties. In further embodiments, bladder **30** may incorporate two or more separate sealed chambers positioned in other portions of bladder **30**. Accordingly, the configurations of the separate sealed chambers, as well as the pressures of the fluid within the chambers may vary significantly within the scope of the present invention.

The sole structures of conventional articles of athletic footwear generally incorporates a polymer foam material, such as polyurethane or ethylvinylacetate. One drawback to polymer foam relates to the concept of compression set. As an individual utilizes an article of footwear, the sole structure is repetitively compressed. Polymer foam materials generally incorporate various gas-filled cells that may collapse or otherwise deteriorate following repetitive compressions, thereby modifying the ground reaction force attenuation or stability properties of the sole structure. In contrast with the conventional sole structures, sole structure **12**, as described above, does not incorporate a polymer foam material. In some embodiments, as described below, a polymer foam material **18** may be utilized in combination with sole component **20**.

In the various embodiments of sole component **20** discussed above, sole component **20** extends through each of regions **15-17** and, therefore, extends under a substantial portion of the longitudinal length of the foot. Referring to FIGS. **22** and **23**, sole component **20** extends only through heel region **17**, and polymer foam material **18** forms midsole **13** in forefoot region **15** and midfoot region **16**. Sole component **20** may, therefore, extend through only a portion of the longitudinal length of footwear **10**. In further embodiments, sole component **20** may also be limited to a single side of sole structure **12**. For example, the lateral side of sole structure **12**

may incorporate sole component **20**, whereas the medial side incorporates foam material **18**. In yet further embodiments, a portion of bladder **30** may be replaced by foam material **18** such that reinforcing structure **40** extends around both bladder **30** and foam material **18**.

Sole component **20** may be directly bonded to upper **11**, as depicted in FIG. **1**. As an alternative, polymer foam material **18** may extend between sole component **20** and upper **11**, as depicted in FIG. **24**. Accordingly, an upper surface of foam material **18** may be bonded to upper **11**, and sole component **20** may be bonded to a lower surface of foam material **18**. Foam material **18** is depicted as having approximately one-half the height of sole component **20**, but the relative thicknesses of foam material **18** and sole component **20** may vary significantly.

The materials selected for bladder **30** and reinforcing structure **40** may exhibit different mechanical properties, such as the modulus of elasticity. In addition to mechanical properties, however, the materials selected for bladder **30** and reinforcing structure **40** may also exhibit different visual properties. For example, bladder **30** may be formed of a generally clear material, whereas reinforcing structure **40** may be formed of a generally translucent or opaque material. In addition, the colors of bladder **30** and reinforcing structure **40** may vary. Accordingly, examples of visual properties that may vary include the clarity and/or colors of the materials forming sole component **20**.

A sole component **20'** is depicted in FIG. **25** as incorporating a bladder **30'** and a reinforcing structure **40'** bonded to the exterior of bladder **30'**. As with sole component **20**, reinforcing structure **40'** forms a reinforcing cage that is bonded or otherwise secured to an exterior of bladder **30'**. In general, reinforcing structure **40'** generally extends around portions of the periphery of bladder **30'**, and portions of reinforcing structure **40'** extend along side surfaces of bladder **30'**. Reinforcing structure **40'** extends, therefore, between upper and lower surfaces of bladder **30'**. In addition, the material forming reinforcing structure **40'** may exhibit a greater modulus of elasticity than the material forming bladder **30'**. Accordingly, the configuration and material properties of reinforcing structure **40'** may impart reinforcement to bladder **30'**.

When incorporated into an article of footwear, sole component **20'** may be encapsulated within a polymer foam material, such as polyurethane or ethylvinylacetate. Accordingly, sole component **20'** may replace a conventional fluid-filled bladder within a conventional sole structure of an article of footwear. Portions of sole component **20'** may be exposed through apertures in the foam material so as to be visible from an exterior of the footwear, or sole component **20'** may be entirely encapsulated by the foam material. Sole component **20'** may also have more than one chamber with fluids of differing pressure.

Another consideration in the structure of sole component **20** relates to the relative compressibilities of various portions of sole component **20**. During walking, running, or other ambulatory activities, sole component **20** is compressed between the ground and the foot, and portions of sole component **20** deform accordingly. One factor that affects the stability of footwear **10** is the degree to which lower surface **22** and side surfaces **23** and **24** compresses or otherwise deform during an applied load. If, for example, the portion of lower surface **22** adjacent to lateral side surface **23** compresses to a greater degree than the portion of lower surface **22** adjacent to medial side surface **24**, then the portion of sole component **20** supporting the lateral side of the foot may become unstable and permit the foot to roll toward the lateral side. The degree to which surfaces of sole component **20**

compress or otherwise deform in reaction to an applied load may be limited through the addition of a supplemental layer **60**, as depicted in FIGS. **26-27B**. In addition, supplemental layer **60** may reduce the probability that relatively sharp objects (e.g., stones, thorns, nails) will puncture bladder **30**.

Supplemental layer **60** is bonded to lower surface **22** and increases the resistance of sole component **20** to deformation, thereby increasing the overall stability of footwear **10**. As depicted in the figures, supplemental layer **60** does not extend upward and into the various contours associated with interior bonds **34** and flexion indentations **35**, thereby permitting the portions of lower barrier layer **32** that form the contours to compress without the additional resistance imparted by supplemental layer **60**. In some embodiments, however, supplemental layer **60** may extend into the various contours associated with interior bonds **34** and flexion indentations **35**, or supplemental layer **60** may extend into selected contours. As an example, supplemental layer **60** may extend into contours proximal to medial side surface **24** in order to resist pronation (i.e., an inward roll) of the foot. Furthermore, supplemental layer **60** may define various apertures in areas corresponding with interior bonds **34**.

Supplemental layer **60** is also depicted as extending throughout lower surface **23**. In some embodiments, however, supplemental layer **60** may be positioned only in heel region **17** or only on portions of lower surface **22** that are adjacent to medial side surface **24**. Supplemental layer **60** may also form an aperture that places the material of supplemental layer adjacent to edges of lower surface **22**. Accordingly, the position of supplemental layer **60** may vary significantly.

Supplemental layer **60** may be formed from any of the materials discussed above for barrier layers **31** and **32**. When, for example, barrier layers **31** and **32** are formed from a thermoplastic polyurethane material, supplemental layer **60** may also be formed from a thermoplastic polyurethane to facilitate bonding between the layers. The thickness of supplemental layer **60** has an effect upon the degree to which compression of sole component **20** is limited. In general, a greater thickness for supplemental layer **60** imparts a greater resistance to compression, and a lesser thickness imparts a lesser resistance to compression. As discussed above, a suitable thickness range for lower barrier layer **32** prior to molding is 0.03 to 0.10 inches, with one preferred thickness being 0.055 inches. Supplemental layer **60** may also have a thickness in this range, but may extend beyond this range depending upon the desired degree of compression resistance.

A further configuration for sole component **20** is depicted in FIG. **28**. In contrast with the generally horizontal configuration of interior bonds **34** depicted in FIGS. **9A, 9B, and 9E**, FIG. **28** discloses a pair of interior bonds **34'** between barrier layers **31** and **32** that are inclined or otherwise sloped. As discussed above, the relative elevations of interior bonds **34** affect the degree of stretching that occurs in barrier layers **31** and **32**. If, for example, interior bonds **34** are located closer to lower surface **22** than upper surface **21**, then upper barrier layer **31** must stretch downward to form the indentations associated with interior bonds **34**. Similarly, locating interior bonds **34** closer to upper surface **21** causes lower barrier layer **32** to stretch upward to form the indentations associated with interior bonds **34**. The degree of stretch in portions of barrier layers **31** and **32** affects the thickness of barrier layers **31** and **32**. Accordingly, the position of interior bonds **34** has an effect upon the thickness of barrier layers **31** and **32**.

Interior bonds **34'** are inclined with respect to a plane of upper surface **21** or lower surface **22**. More particularly, interior bonds **34'** are oriented to form a downward incline extending away from each of side surfaces **23** and **24**. This

orientation places the higher portions of interior bonds 34' adjacent to side surfaces 23 and 24, and the areas of upper barrier layer 31 adjacent to side surfaces 23 and 24 stretch to a relatively small degree to form interior bonds 34'. That is, the stretch in upper barrier layer 31 is lessened adjacent to side surfaces 23 and 24 due to the configuration of interior bonds 34'. The lessened stretch in this area provides upper barrier layer 31 with greater thickness, thereby increasing the durability and stability of upper barrier layer 31 adjacent to side surfaces 23 and 24.

The orientation of interior bonds 34' places the lower portions of interior bonds 34' closer to a central area of sole component 20, and the areas of upper barrier layer 31 adjacent to the central area stretch to a relatively large degree to form interior bonds 34'. That is, the stretch in upper barrier layer 31 is increased in the central area due to the configuration of interior bonds 34'. The increased stretch in this area provides upper barrier layer 31 with lesser thickness, thereby increasing the compressibility of upper barrier layer 31 in the central area.

The configuration of bonds between barrier layers 31 and 32 may vary from the specific configuration depicted in FIG. 28. For example, all bonds between barrier layers 31 and 32 may have an inclined configuration similar to interior bonds 34'. In some articles of footwear, the incline of interior bonds 34' may be reversed such that interior bonds 34' are oriented to form an upward incline extending away from each of side surfaces 23 and 24. FIG. 28 depicts a cross-section through a portion of sole component 20 in forefoot region 15, but inclined bonds between barrier layers 31 and 32 may be located in any region of footwear 10.

Another consideration related to the manufacturing process for sole component 20 relates to the degree of curvature in surfaces 21-24. FIGS. 13A and 13B depict lower mold portion 120 as having a generally planar area for forming lower surface 22. When sole component 20 is removed from mold 100 and is in the uninflated and unpressurized state, lower surface 22 will exhibit, therefore, a generally planar configuration. Depending upon the degree to which sole component 20 is pressurized, lower surface 22 may bow outward to impart a generally convex configuration to lower surface 22. In order to limit the degree to which lower surface 22 bows outward and exhibits the generally convex configuration, lower mold portion 120 may be formed to have a convex area for forming lower surface 22, thereby imparting a concave shape to lower surface 22 in the unpressurized state.

With reference to FIG. 29A, sole component 20 is depicted in the uninflated configuration and lower surface 22 exhibits a generally concave configuration. As noted above, providing lower mold portion 120 with a convex area for forming lower surface 22 will impart a concave configuration to lower surface 22. Upon pressurization, however, the fluid exerts an outward force upon lower barrier layer 32 and deforms lower surface 22 to a generally planar configuration, as depicted in FIG. 29B. An advantage of providing lower surface 22 with a planar configuration, as opposed to a convex configuration, is that the overall stability of footwear 10 may be increased.

Initially forming lower surface 22 to exhibit a concave configuration provides an effective manner of imparting a generally planar configuration to lower surface 22 upon pressurization. Similar concepts may also be applied to upper surface 21 and side surfaces 23 and 24. That is, upper surface 21 and side surfaces 23 and 24 may also be formed to exhibit a concave configuration following molding in order to impart a generally planar configuration upon pressurization. More generally, the shape of mold 100 may be utilized to impart any

configuration (i.e., concave, planar, or convex) to surfaces 21-24 depending upon the application and desired configuration for sole component 20.

As discussed above, two or more materials may be incorporated into reinforcing structure 40 in some embodiments of the invention. With reference to FIGS. 30A and 30B, upper portion 41 is formed from a first material 61, and lower portion 42 and connecting portions 43 are formed from a second material 62. As an example, first material 61 may exhibit lesser stiffness than second material 62. This configuration provides a softer material adjacent to upper 11, which may enhance the comfort of footwear 10 and promote bonding between sole structure 12 and upper 11. In addition, this configuration promotes bending of sole component 20 during walking, running, or other ambulatory activities. Another configuration is depicted in FIGS. 31A and 31B, in which portions of reinforcing structure 40 in medial side surface 24 are formed of first material 61 and a remainder of reinforcing structure 40 is formed of second material 62. In this configuration, portions of reinforcing structure 40 corresponding with lateral side surface 23 are formed with lesser stiffness than the portions of reinforcing structure 40 corresponding with medial side surface 24 to resist pronation of the foot. In addition, some embodiments may vary the materials throughout reinforcing structure 40 in order to provide specific compression, stability, and flexibility properties to particular portions of reinforcing structure 40. In addition to first material 61 and second material 62, reinforcing structure 40 may be formed from further materials. As an example, first material 61 may form portions of reinforcing structure 40 in forefoot region 15, second material 62 may form portions of reinforcing structure 40 in midfoot region 16, and a third material may form portions of reinforcing structure 40 in heel region 17, for example. Accordingly, the positions and numbers of materials that may be incorporated into reinforcing structure 40 may vary significantly.

Variations in the dimensions of portions of reinforcing structure 40 may have an effect upon the ground reaction force attenuation properties of sole component 20, the compressibility of sole component 20, the flexibility of sole component 20, or the torsional force necessary to twist sole component 20, for example. With reference to FIG. 32, sole component 20 is depicted as having a configuration wherein a connecting member 43 located in lateral side surface 23 exhibits greater thickness than a connecting member 43 located in medial side surface 24. During court-style athletic activities, such as tennis and basketball, providing additional support for a lateral side of the foot may prevent rolling of the foot toward the lateral side during lateral cuts or other sideways movements. By increasing the thickness of connecting members 43 located in lateral side surface 23, additional support may be provided for the lateral side of the foot. As an alternative, connecting members 43 located in medial side surface 24 may exhibit increased thickness to limit pronation of the foot during running. Accordingly, variations in the thickness of selected connecting members 43 may be utilized to control motions of the foot or affect other properties of sole component 20.

An increase in the width of various connecting members 43 may also affect the ground reaction force attenuation properties, compressibility, and flexibility of sole component 20. With reference to FIG. 33, sole component 20 is depicted in a configuration wherein connecting members 43 exhibit an increased width in comparison with FIG. 8, for example. By increasing the width of connecting members 43 located in lateral side surface 23, additional support may be provided for the lateral side of the foot. As an alternative, connecting

members **43** located in medial side surface **24** may exhibit increased width to limit pronation of the foot during running. Accordingly, variations in the width of selected connecting members **43** may be utilized to control motions of the foot or affect other properties of sole component **20**.

With reference to FIGS. **34-35B**, another embodiment is depicted wherein bladder **30** includes various indented areas **63** that receive side portions of outsole **14**. Indented areas **63** may be located in any region of footwear **10**, but are depicted as being located at an interface of regions **15** and **16** and also throughout heel region **17**. That is, indented areas **63** are located at the lower portion of side surfaces **23** and **24**. Indented areas **63** are depressions in bladder **30** that permit the side portions of outsole **14** to wrap upward and onto one or both of side surfaces **23** and **24**, as depicted in FIGS. **36-37B**. As depicted in **36-37B**, indented areas **63** ensure that outsole **14** is flush with the exterior surface of reinforcing structure **40** and the exterior of side surfaces **23** and **24**. In some athletic activities, portions of side surfaces **23** and **24**, rather than lower surface **22**, make contact with the ground. An advantage of having outsole **14** wrap upward and onto one or both of side surfaces **23** and **24** is that outsole **14** limits sliding between the ground and side surfaces **23** and **24** when either of side surfaces **23** and **24** make contact with the ground.

Although indented areas **63** are discussed above as ensuring that outsole **14** is flush with the exterior surface of reinforcing structure **40** and the exterior of side surfaces **23** and **24**, outsole **14** may not be flush in all configurations of sole component **20**. With reference to FIG. **37C**, indented areas **63** are absent and outsole **14** extends outward and beyond the exterior surface of reinforcing structure **40** and the exterior of side surfaces **23** and **24**. Accordingly, indented areas **63** may be absent in some embodiments.

In many of the embodiments discussed above, sole component **20** extends entirely through a longitudinal length of footwear **10**. The various concepts discussed above, however, may be applied to another sole component **20** that only extends through a portion of the length of footwear **10**. With reference to FIG. **38**, footwear **10** is depicted as including a sole component **20** that extends through heel region **17** and a portion of midfoot region **16**. In midfoot region **16**, sole component **20** tapers downward to form a tapered area **64**, as depicted in each of FIGS. **39A** and **39B**, that interfaces with a foam element **65**. More particularly, upper surface **21** approaches lower surface **22** to decrease a thickness of bladder **30** in the tapered area. Foam element **65** extends above the tapered area and contacts upper surface **21**. Whereas sole component **20** is located in a rear area of footwear **10**, foam element **65** extends forward from sole element **20** and through forefoot region **15**. In some embodiments, sole component **20** may be limited to forefoot region **15**, and a foam element may extend rearward and through heel region **17**. Alternately, sole component **20** may be limited to midfoot region **16** such that a pair of foam elements extend through each of regions **15** and **17**.

As discussed above, supplemental layer **60** may be applied to control the degree to which surfaces of sole component **20** compress or otherwise deform in reaction to an applied load. As an alternative to supplemental layer **60** or in addition to supplemental layer **60**, outsole **14** may be structured to control the degree to which surfaces of sole component **20** compress or otherwise deform. With reference to FIG. **40A**, outsole **14** is depicted as having a first area **14a** and a second area **14b**. First area **14a** is primarily located in heel region **17**, whereas second area **14b** is located in each of forefoot region **15** and midfoot region **16**. In comparison with second area

14b, first area **14a** may exhibit a stiffer structure to assist with controlling the degree to which surfaces of sole component **20** compress or otherwise deform in reaction to an applied load. Another configuration is depicted in FIG. **40B**, wherein first area **14** has a U-shaped design.

CONCLUSION

The preceding discussion disclosed various embodiments of a sole component and a method of manufacturing the sole component. In general, the sole component includes a fluid-filled bladder and a reinforcing structure extending around the bladder. The reinforcing structure is bonded to the exterior of the bladder, and may be recessed into the bladder. In some embodiments, the reinforcing structure extends along the side surfaces of the bladder and between upper and lower surfaces of bladder. In manufacturing the sole component, the reinforcing structure may be located within a mold, and the polymer material forming the bladder may be bonded to the reinforcing structure during the molding process.

The present invention is disclosed above and in the accompanying drawings with reference to a variety of embodiments. The purpose served by the disclosure, however, is to provide an example of the various features and concepts related to the invention, not to limit the scope of the invention. One skilled in the relevant art will recognize that numerous variations and modifications may be made to the embodiments described above without departing from the scope of the present invention, as defined by the appended claims.

That which is claimed is:

1. A method for manufacturing a sole component of an article of footwear, the method comprising steps of:
 - forming an unpressurized bladder having a first surface and an opposite second surface, at least a portion of the second surface having a concave configuration;
 - recessing a reinforcing structure into the bladder and bonding the reinforcing structure to the bladder; and
 - pressurizing the bladder to extend the second surface from the concave configuration to a substantially planar configuration.
2. The method recited in claim 1, wherein the step of forming includes defining a sidewall extending between the first surface and the second surface.
3. The method recited in claim 2, wherein the step of recessing includes securing at least a portion of the reinforcing structure to the sidewall.
4. The method recited in claim 2, further including a step of bonding the first surface to the second surface to form a plurality of interior bonds spaced inward from the sidewall.
5. The method recited in claim 4, wherein the step of bonding includes orienting at least one of the interior bonds to be sloped relative to a plane of the first surface.
6. A method for manufacturing a sole component of an article of footwear, the method comprising steps of:
 - forming an unpressurized bladder having a first surface, an opposite second surface, and a sidewall extending between the first surface and the second surface at least a portion of the second surface having a concave configuration;
 - bonding the first surface to the second surface to form a plurality of interior bonds spaced inward from the sidewall;
 - recessing a reinforcing structure into the sidewall and bonding the reinforcing structure to the bladder; and
 - pressurizing the bladder to extend the second surface from the concave configuration to a non-concave configuration.

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7. The method recited in claim 6, wherein the step of bonding includes orienting at least one of the interior bonds to be sloped relative to a plane of the first surface.

8. The method recited in claim 6, wherein the step of pressurizing includes bonding includes extending the second surface to a substantially planar configuration. 5

9. A method for manufacturing a sole component of an article of footwear, the method comprising steps of:

positioning a reinforcing member within a mold such that

the reinforcing member contacts a surface of the mold; 10
shaping a bladder by drawing a polymer material against the surface of the mold and against the reinforcing member, the surface of the mold forming the bladder to have a concave area;

15 extending the polymer material at least partially around the reinforcing member to recess the reinforcing member into the polymer material;

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bonding the polymer material to the reinforcing member; and

pressurizing the bladder to extend the concave area from a concave configuration to a non-concave configuration.

10. The method recited in claim 9, wherein the step of shaping includes defining a first surface, an opposite second surface, and a sidewall of the bladder, the sidewall extending between the first surface and the second surface, and the reinforcing structure being located in at least the sidewall.

11. The method recited in claim 10, further including a step of bonding the first surface to the second surface to form a plurality of interior bonds spaced inward from the sidewall.

12. The method recited in claim 11, wherein the step of bonding includes orienting at least one of the interior bonds to be sloped relative to a plane of the first surface.

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